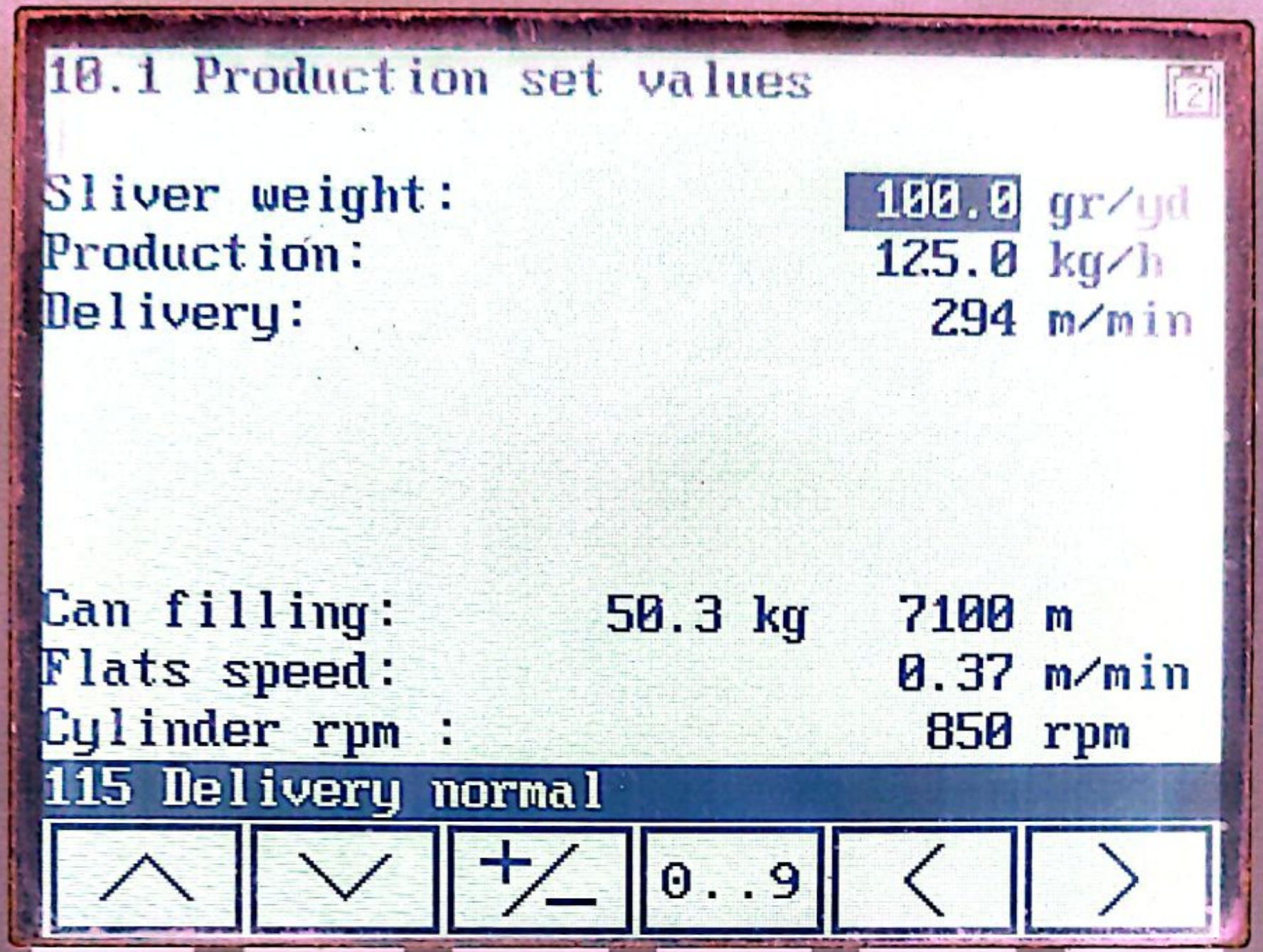
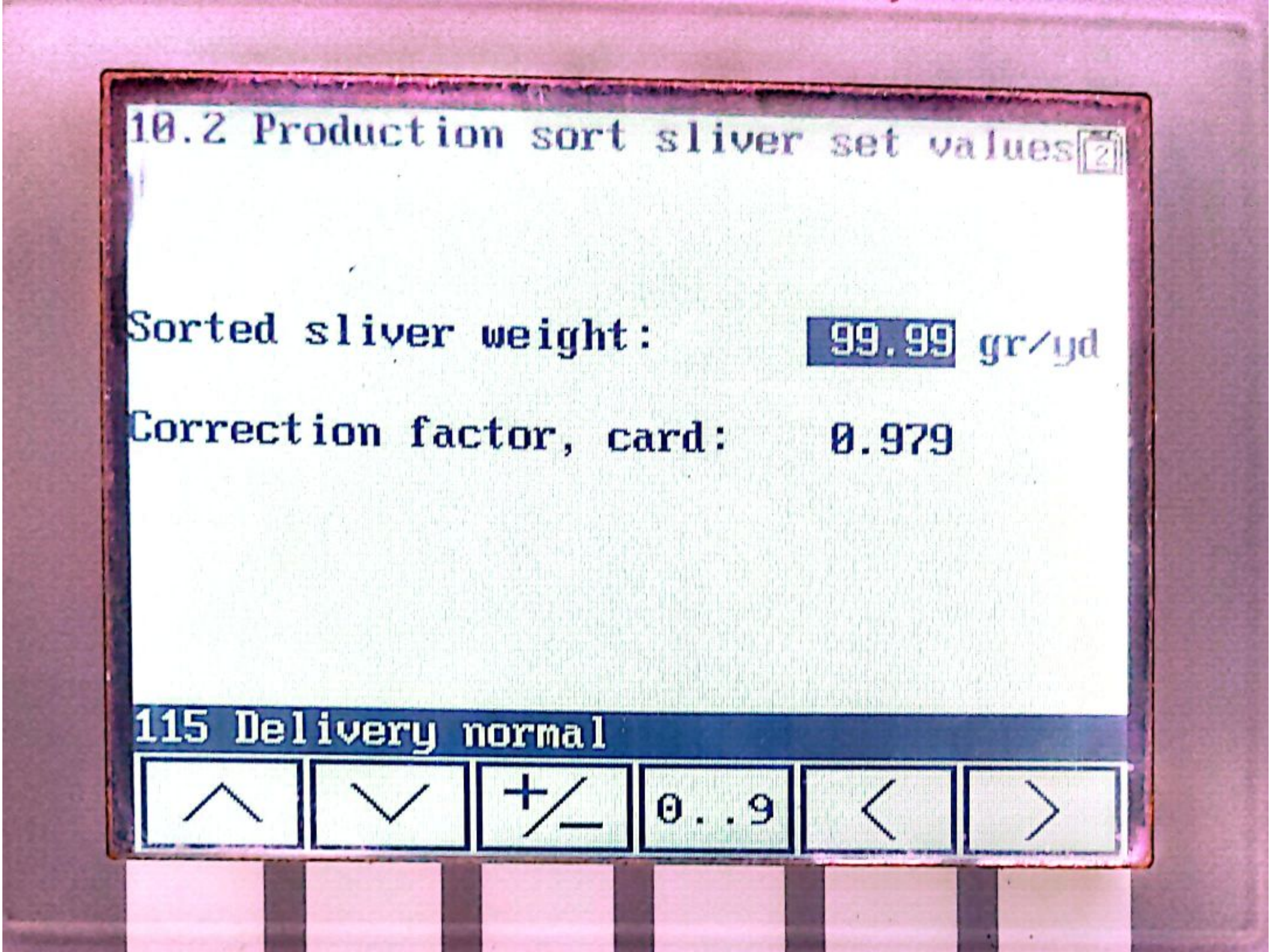
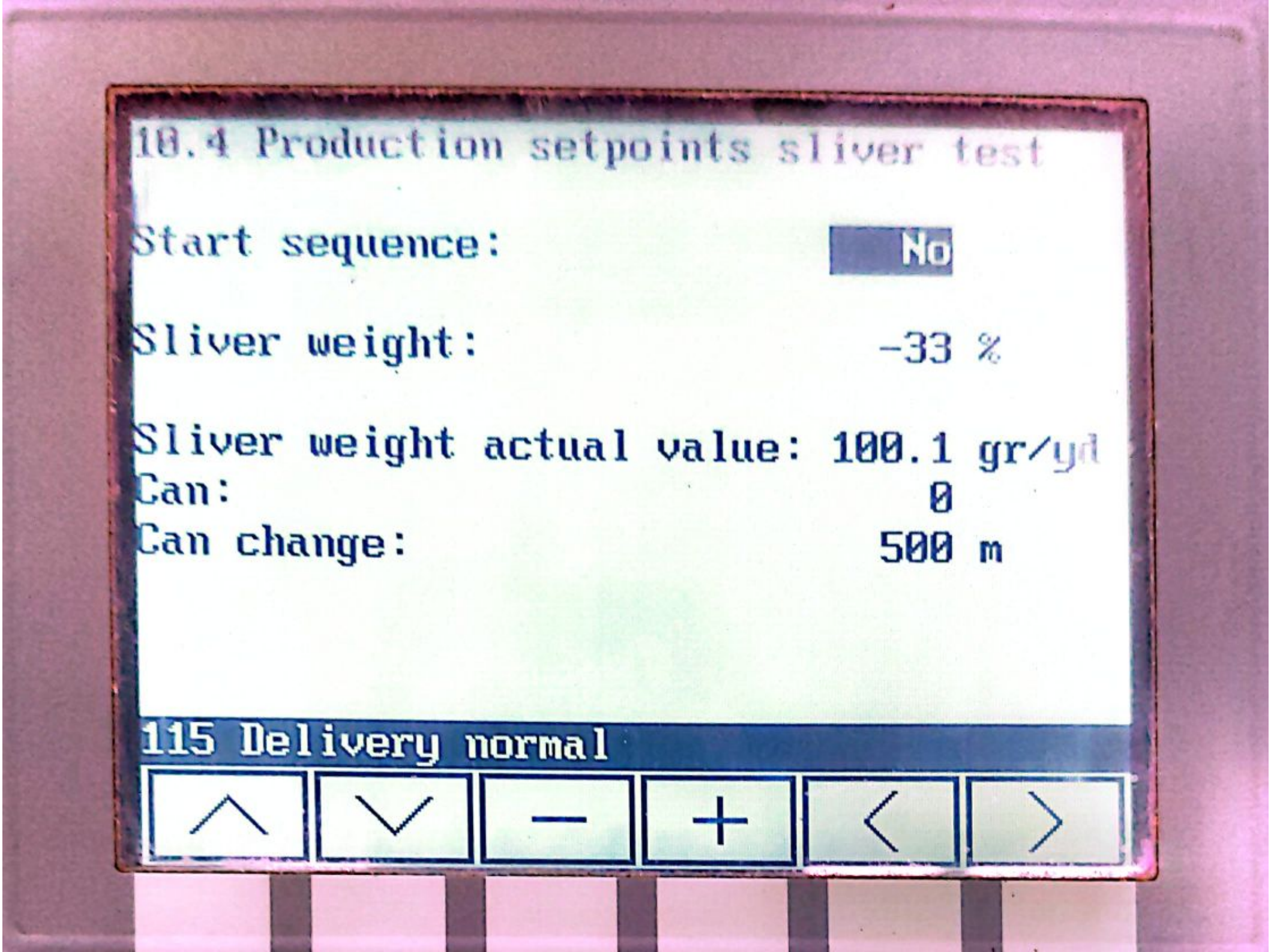
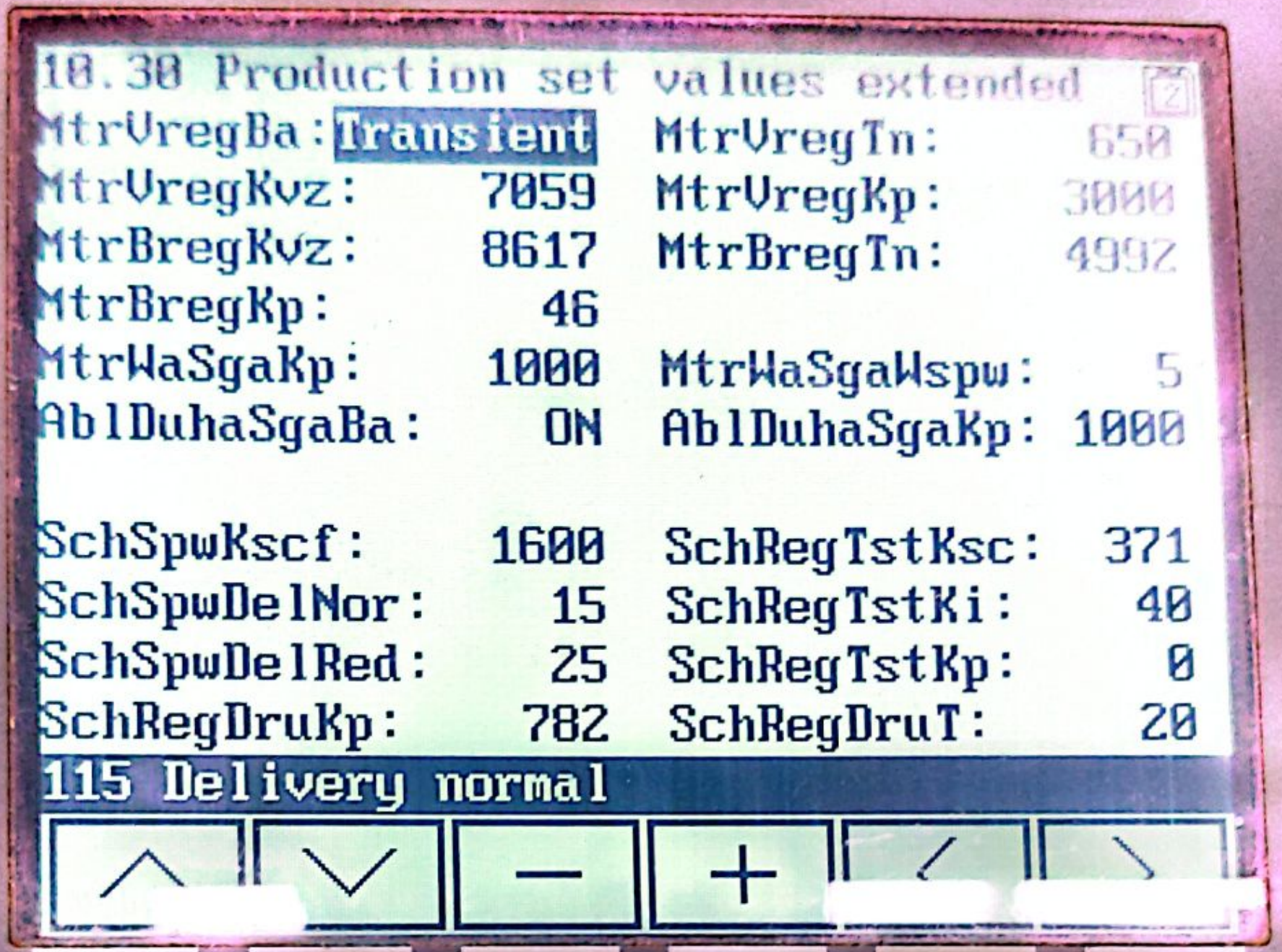
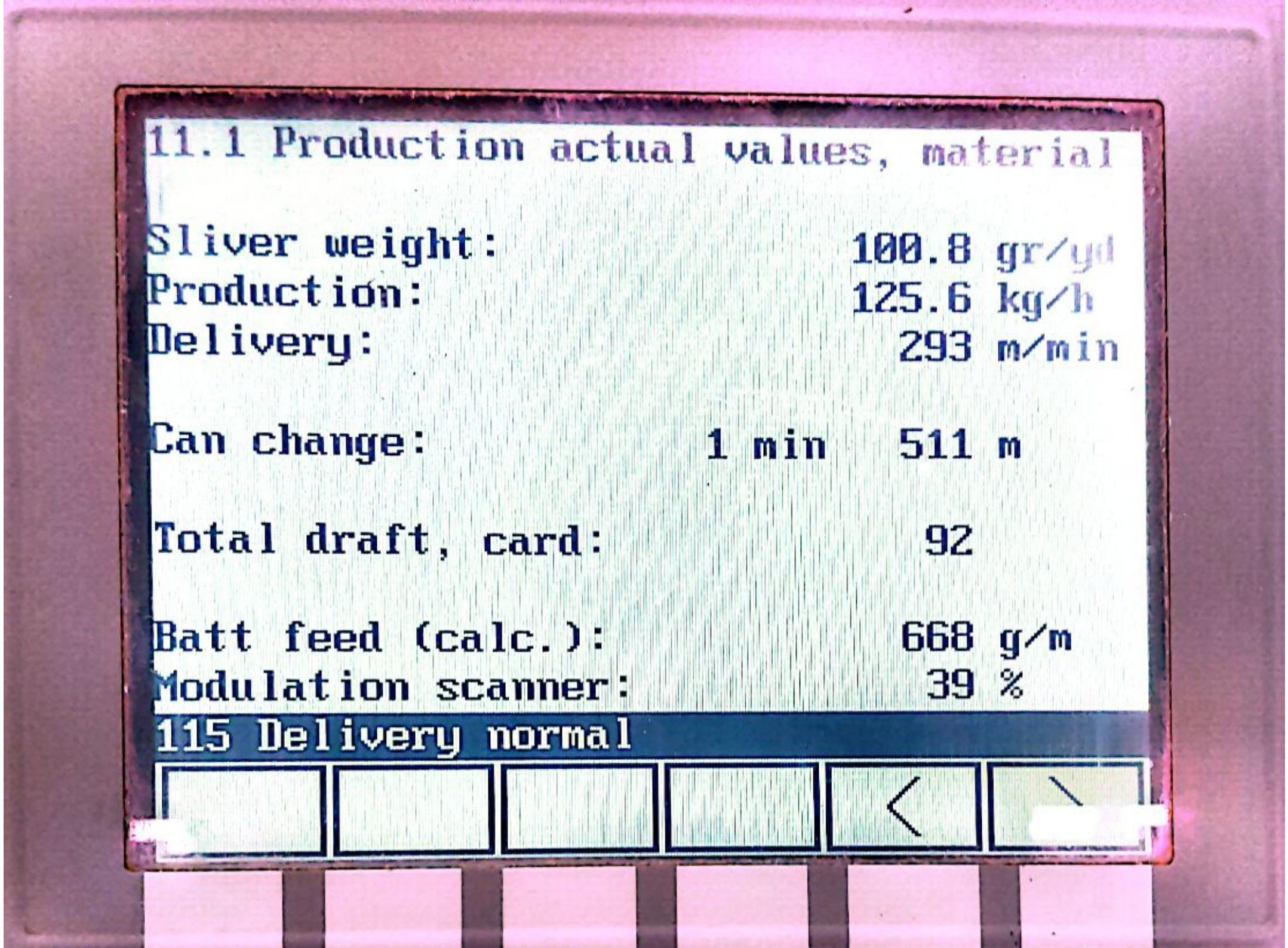
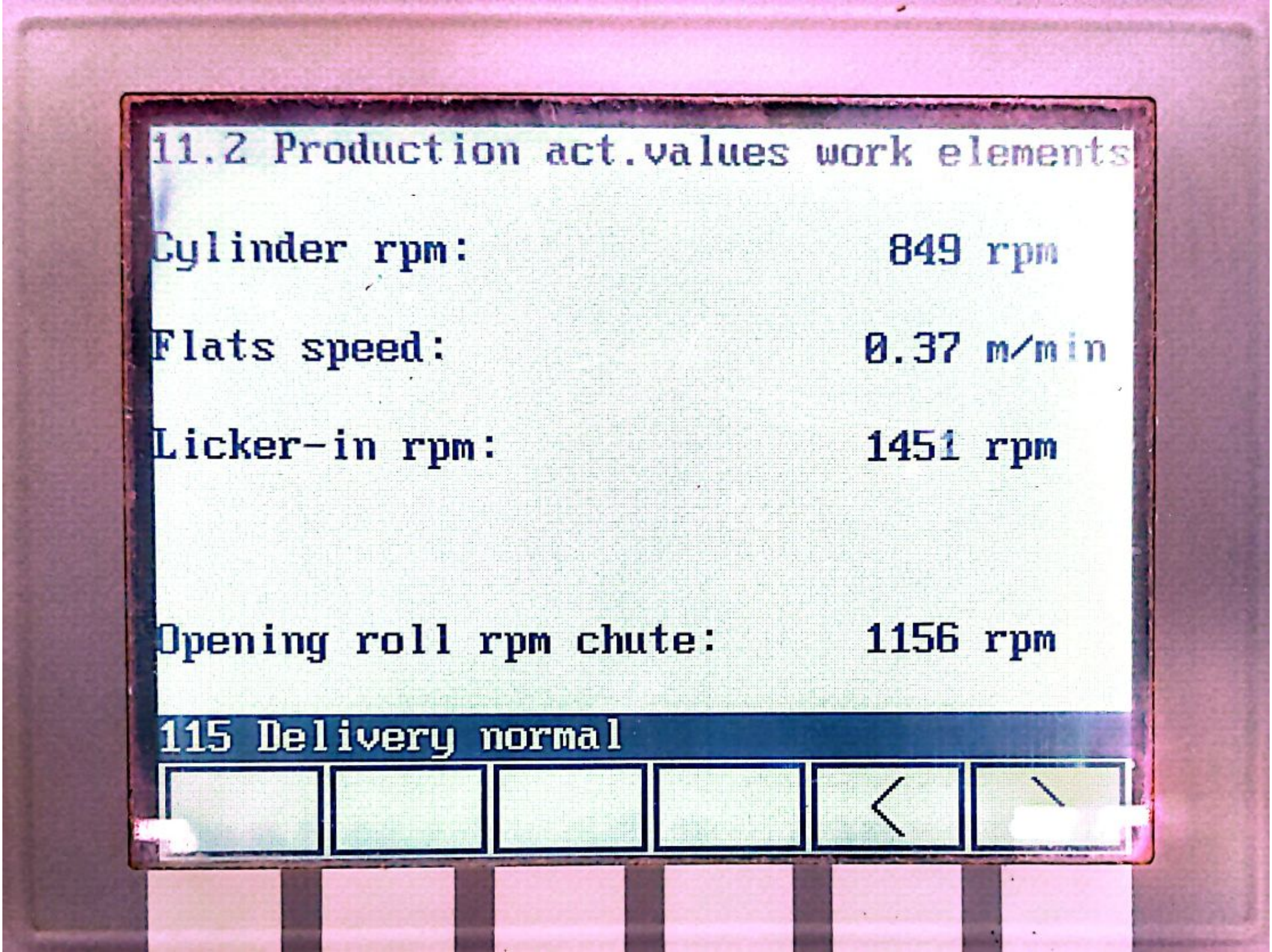

10.1 Production set values
Sliver weight: 100.0 gr/yd
Production: 125.0 kg/h
Delivery: 294 m/min
Can filling: 50.3 kg 7100 m
Flats speed: 0.37 m/min
Cylinder rpm : 850 rpm
115 Delivery normal
0..9

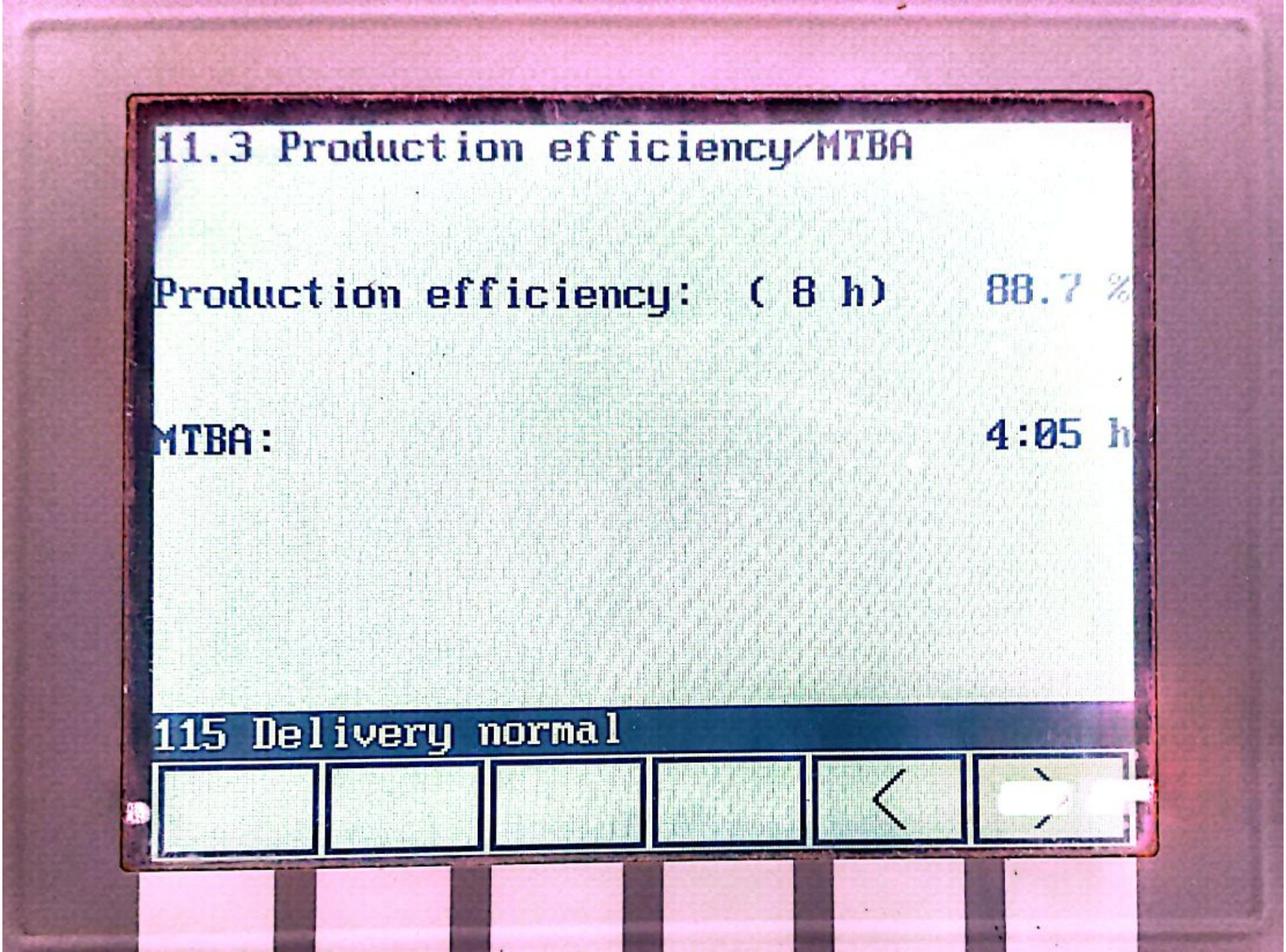

10.2 Production sort sliver set values
2
Sorted sliver weight:
99.99
gr/yd
Correction factor, card:
0.979
115 Delivery normal
+/_
0..9

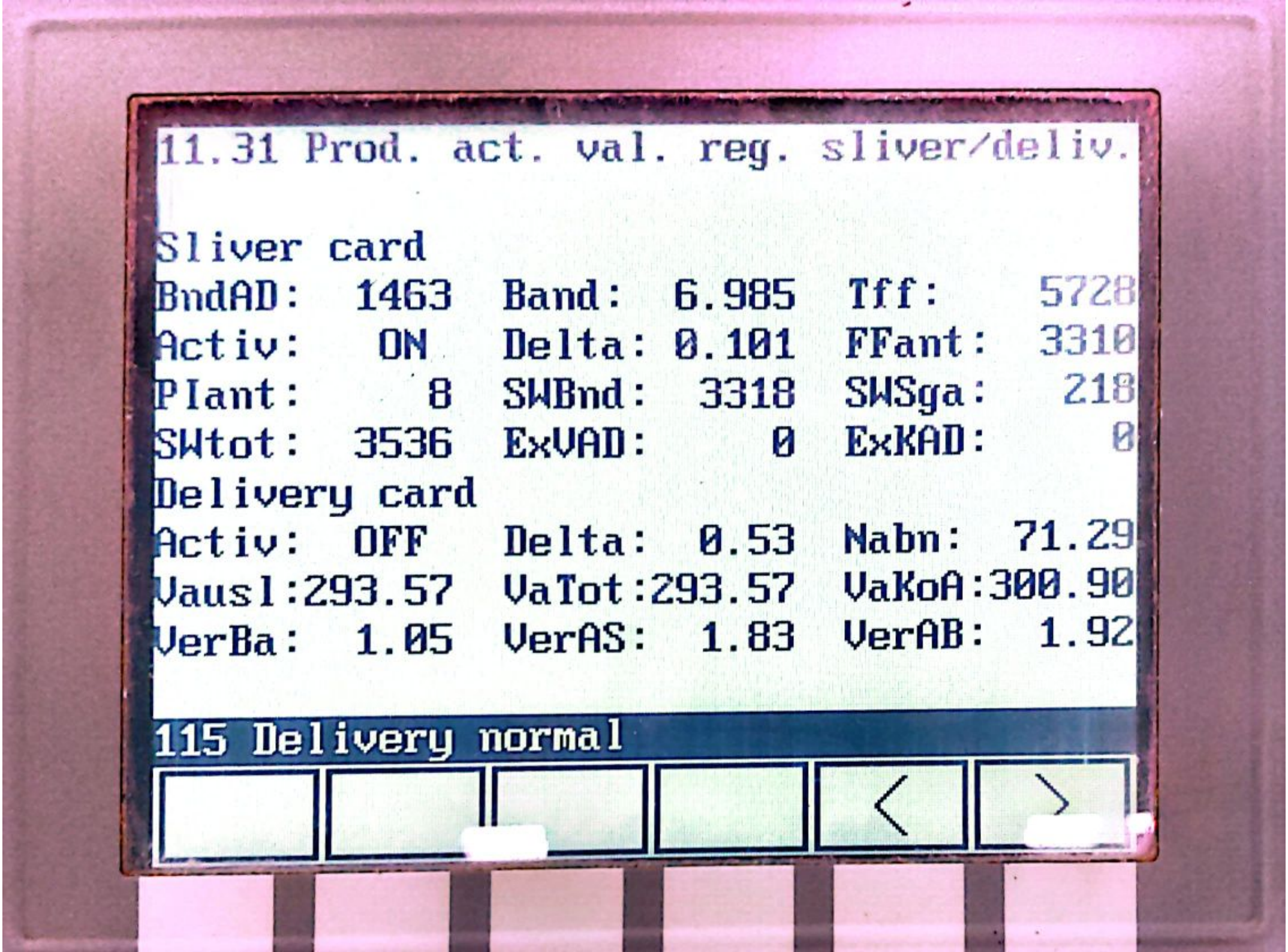

10.4 Production setpoints sliver test
Start sequence: No
Sliver weight: -33 %
Sliver weight actual value: 100.1 gr/yd
Can: 0
Can change: 500 m
115 Delivery normal

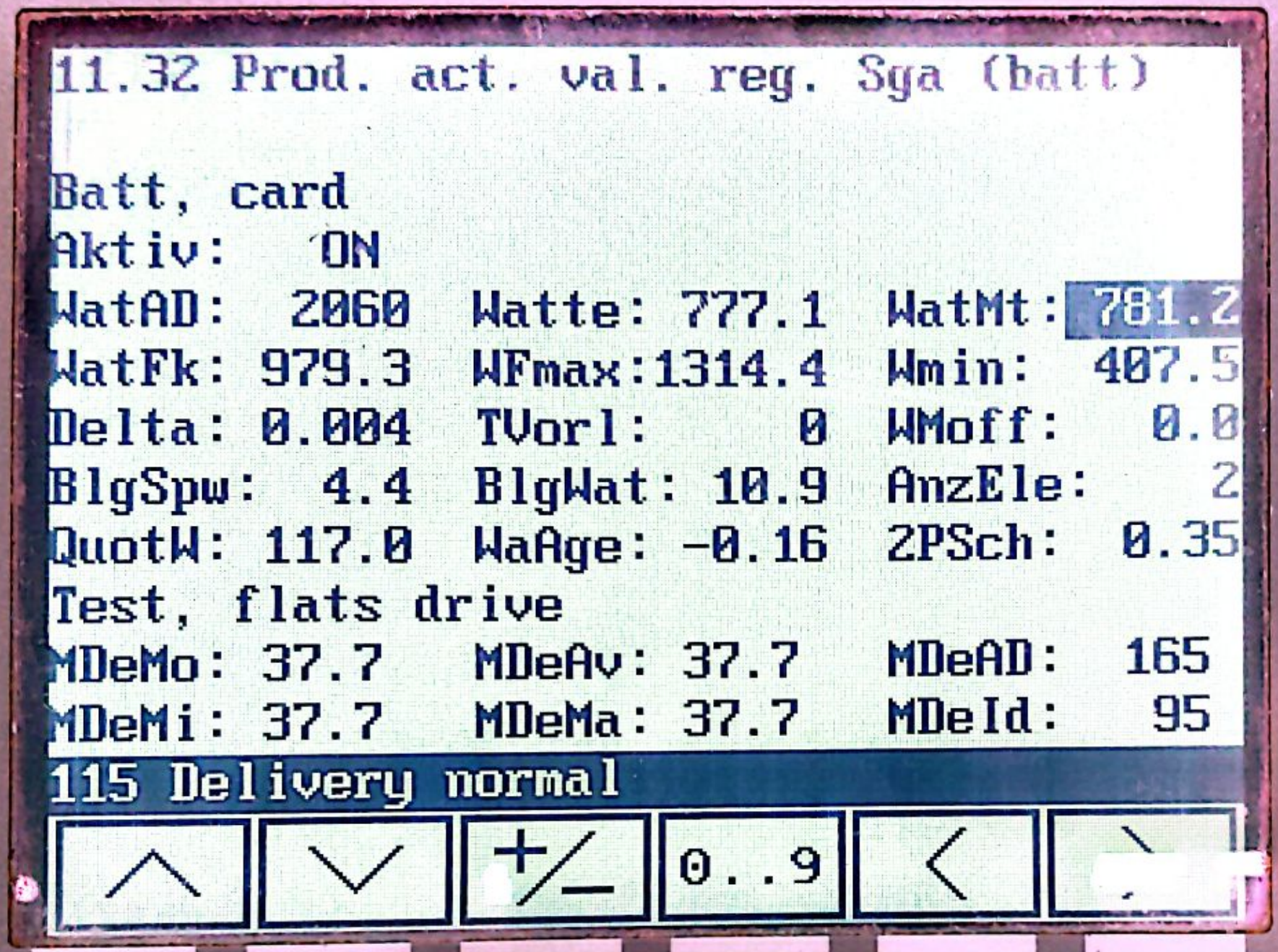

10.30 Production set values extended
MtrVregBa: Transient
MtrVregTn: 650
MtrVregKvz: 7059
MtrVregKp: 3000
MtrBregKvz: 8617
MtrBregTn: 4992
MtrBregKp: 46
MtrWaSgaKp: 1000
MtrWaSgaWspw: 5
AblDuhaSgaBa: ON
AblDuhaSgaKp: 1000
SchSpwKscf: 1600
SchRegTstKsc: 371
SchSpwDelNor: 15
SchRegTstKi: 40
SchSpwDelRed: 25
SchRegTstKp: 0
SchRegDruKp: 782
SchRegDruT: 20
115 Delivery normal

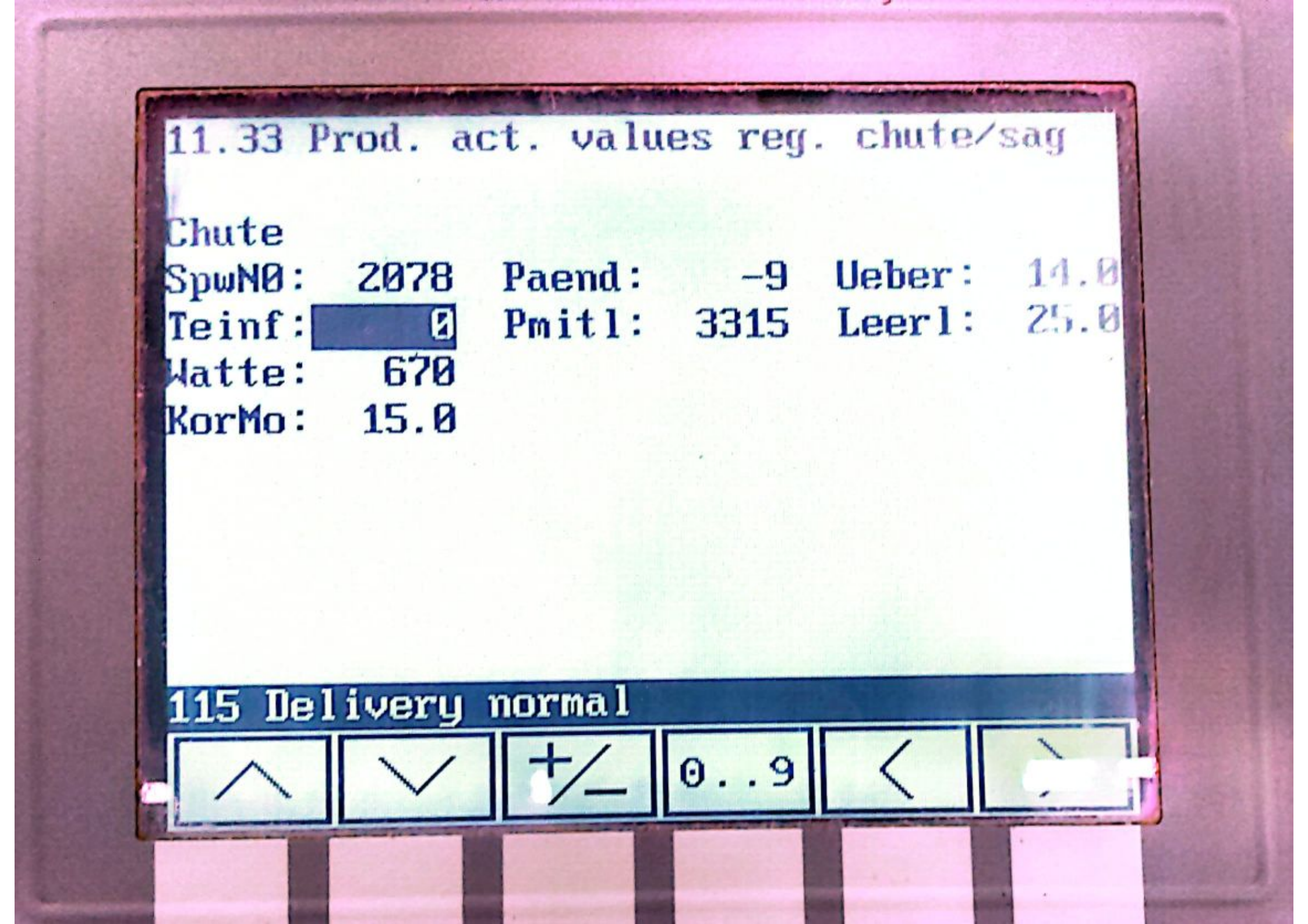

11.1 Production actual values, material
Sliver weight: 100.8 gr/yd
Production: 125.6 kg/h
Delivery: 293 m/min
Can change: 1 min 511 m
Total draft, card: 92
Batt feed (calc.): 668 g/m
Modulation scanner: 39 %
115 Delivery normal

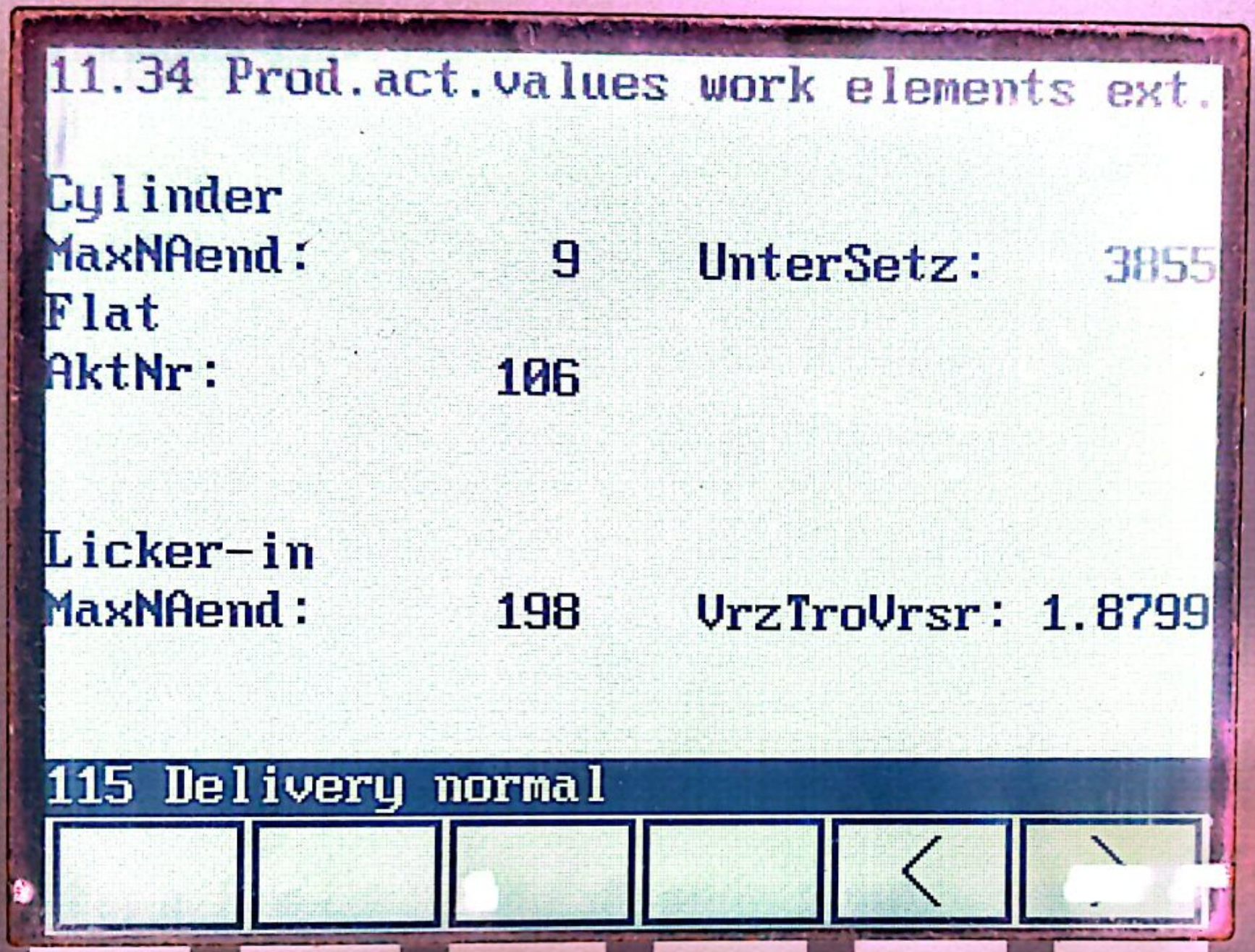

11.2 Production act.values work elements
Cylinder rpm: 849 rpm
Flats speed: 0.37 m/min
Licker-in rpm: 1451 rpm
Opening roll rpm chute: 1156 rpm
115 Delivery normal

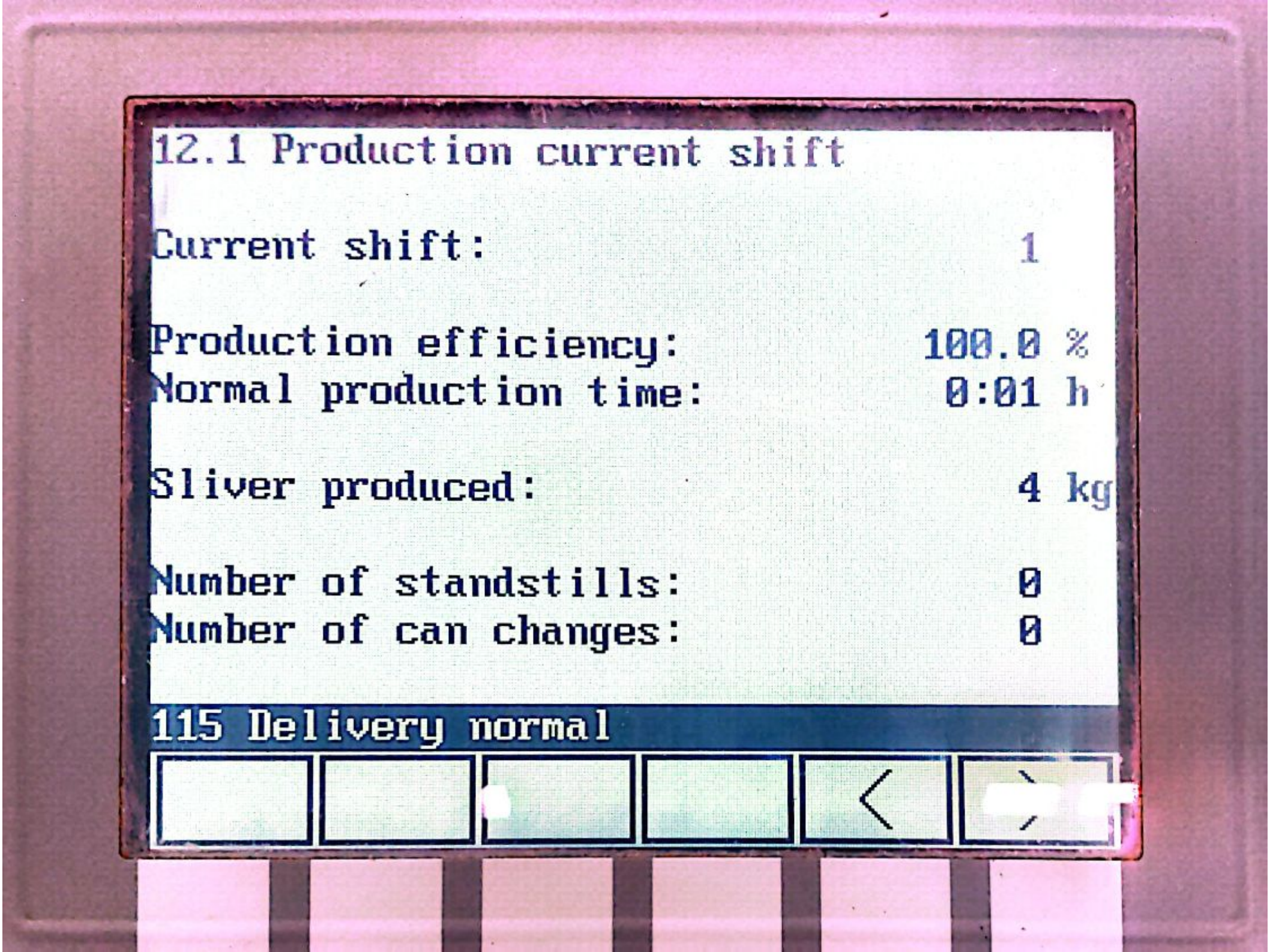

11.3 Production efficiency/MTBA
Production efficiency: (8 h) 88.7 %
MTBA: 4:05 h
115 Delivery normal

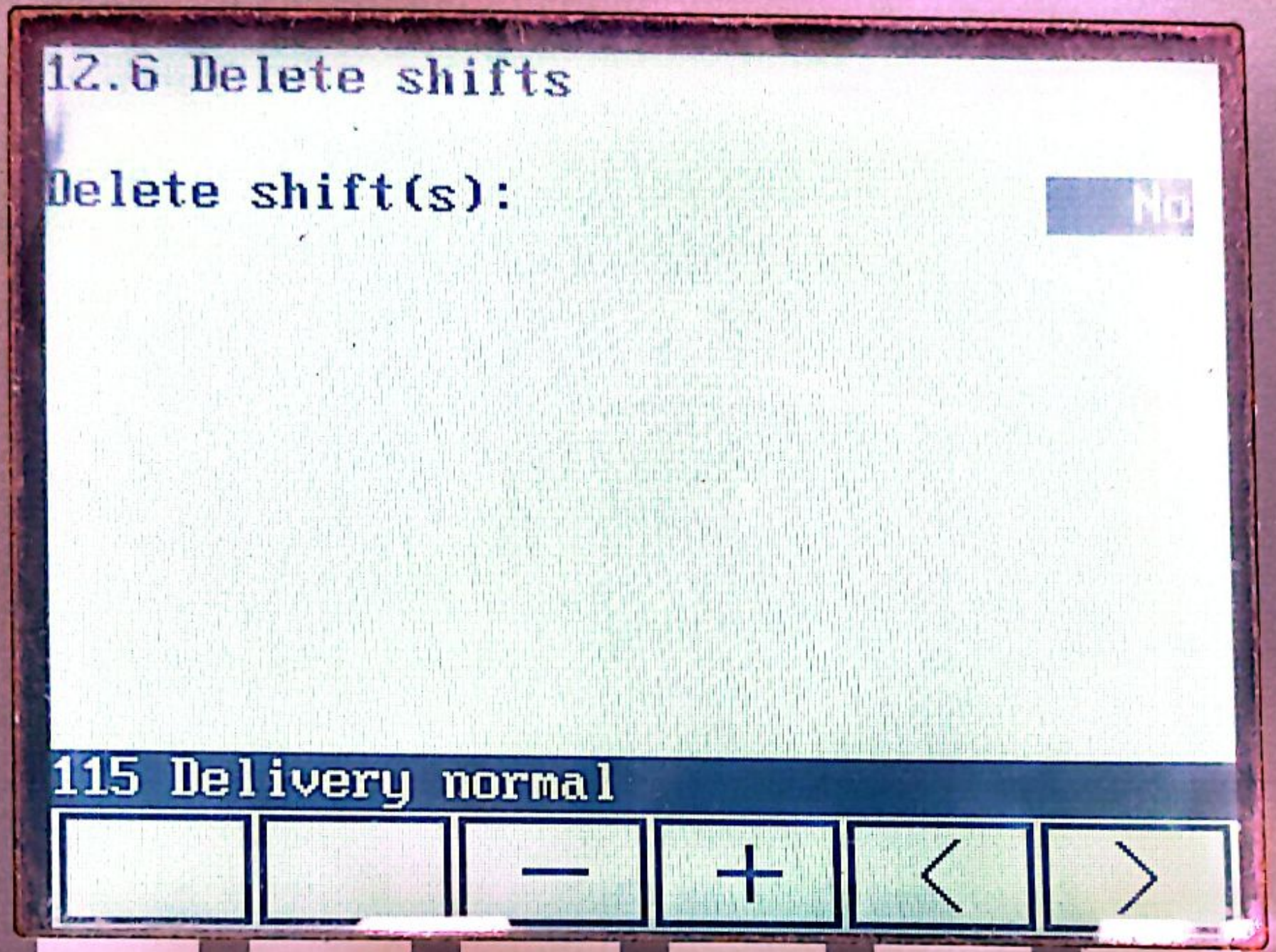

11.31 Prod. act. val. reg. sliver/deliv.
Sliver card
BndAD: 1463 Band: 6.985 Tff: 5728
Activ: ON Delta: 0.101 FFant: 3310
PIant: 8 SWBnd: 3318 SWSga: 218
SWtot: 3536 ExVAD: 0 ExKAD: 0
Delivery card
Activ: OFF Delta: 0.53 Nabn: 71.29
Vausl:293.57 VaTot:293.57 VaKoA:300.90
VerBa: 1.05 VerAS: 1.83 VerAB: 1.92
115 Delivery normal

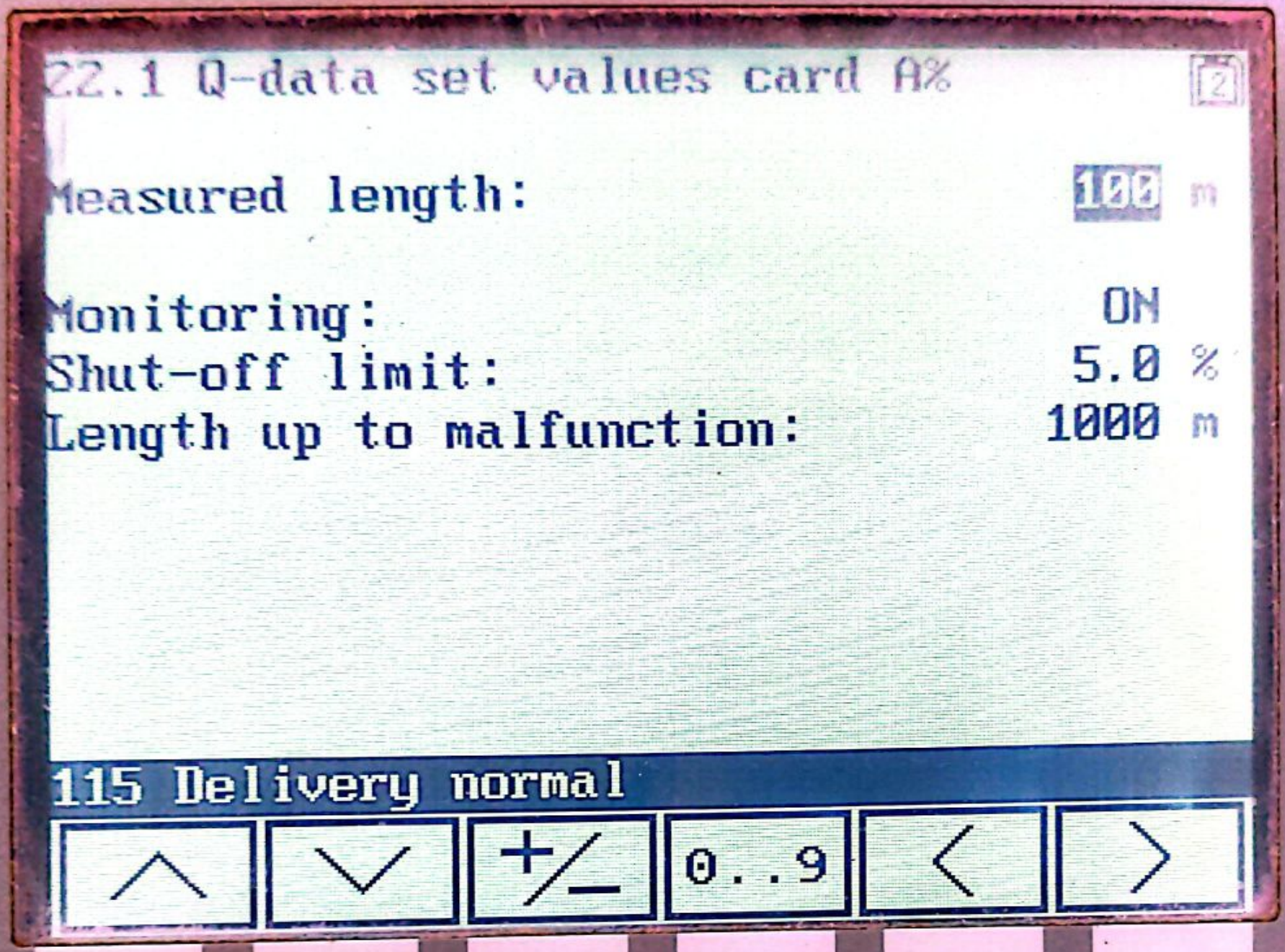

11.32 Prod. act. val. reg. Sga (batt)
Batt, card
Aktiv: ON
WatAD: 2060 Watte: 777.1 WatMt: 781.2
WatFk: 979.3 WFmax:1314.4 Wmin: 407.5
Delta: 0.004 TVorl: 0 WMoff: 0.0
BlgSpw: 4.4 BlgWat: 10.9 AnzEle: 2
QuotW: 117.0 WaAge: -0.16 ZPSch: 0.35
Test, flats drive
MDeMo: 37.7 MDeAv: 37.7 MDeAD: 165
MDeMi: 37.7 MDeMa: 37.7 MDeId: 95
115 Delivery normal
+/_
0..9

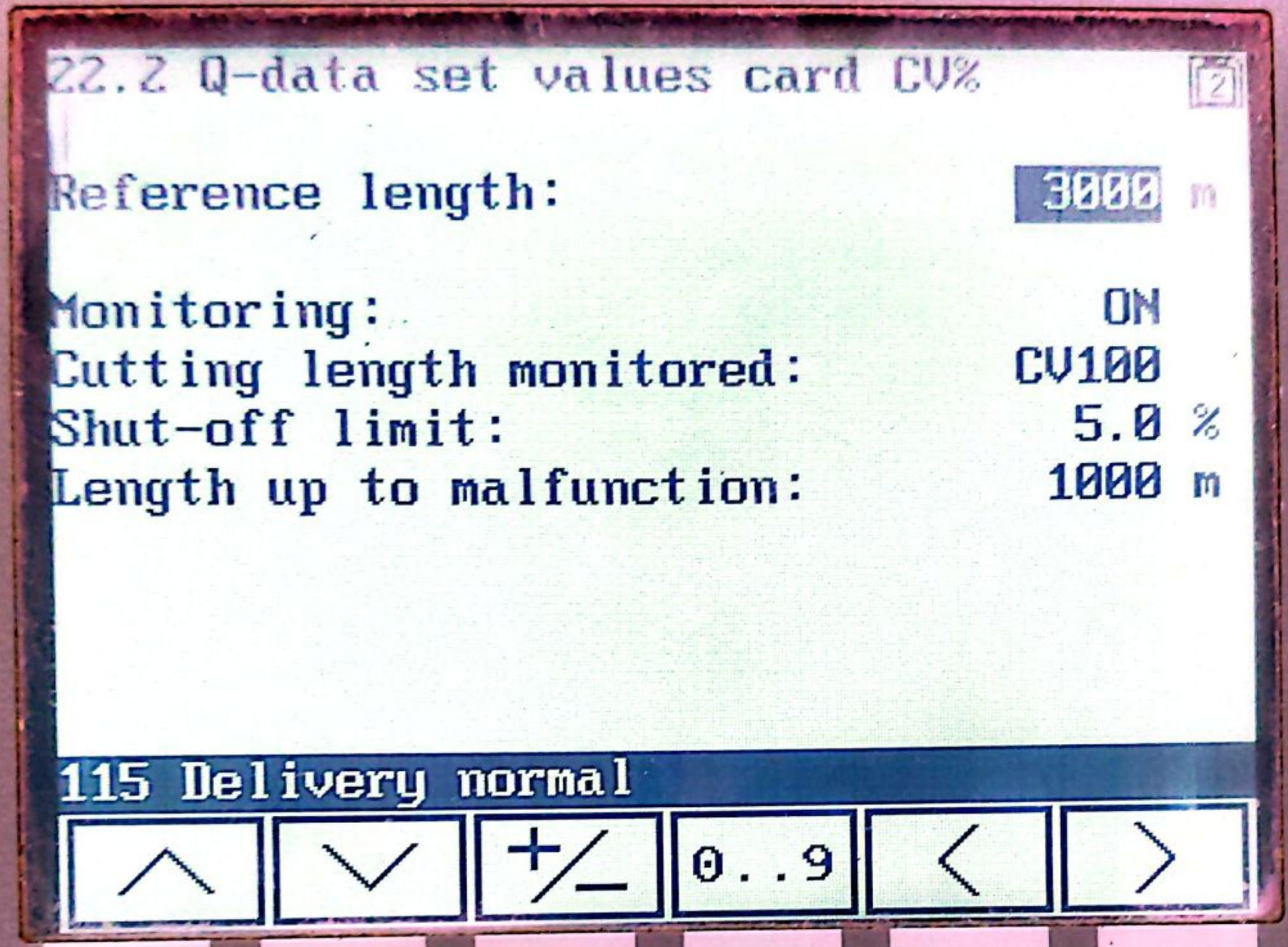

11.33 Prod. act. values reg. chute/sag
Chute
SpwN0: 2078
Paend: -9
Ueber: 14.0
Teinf: 0
Pmitl: 3315
Leerl: 25.0
Watte: 670
KorMo: 15.0
115 Delivery normal
+/_
0..9

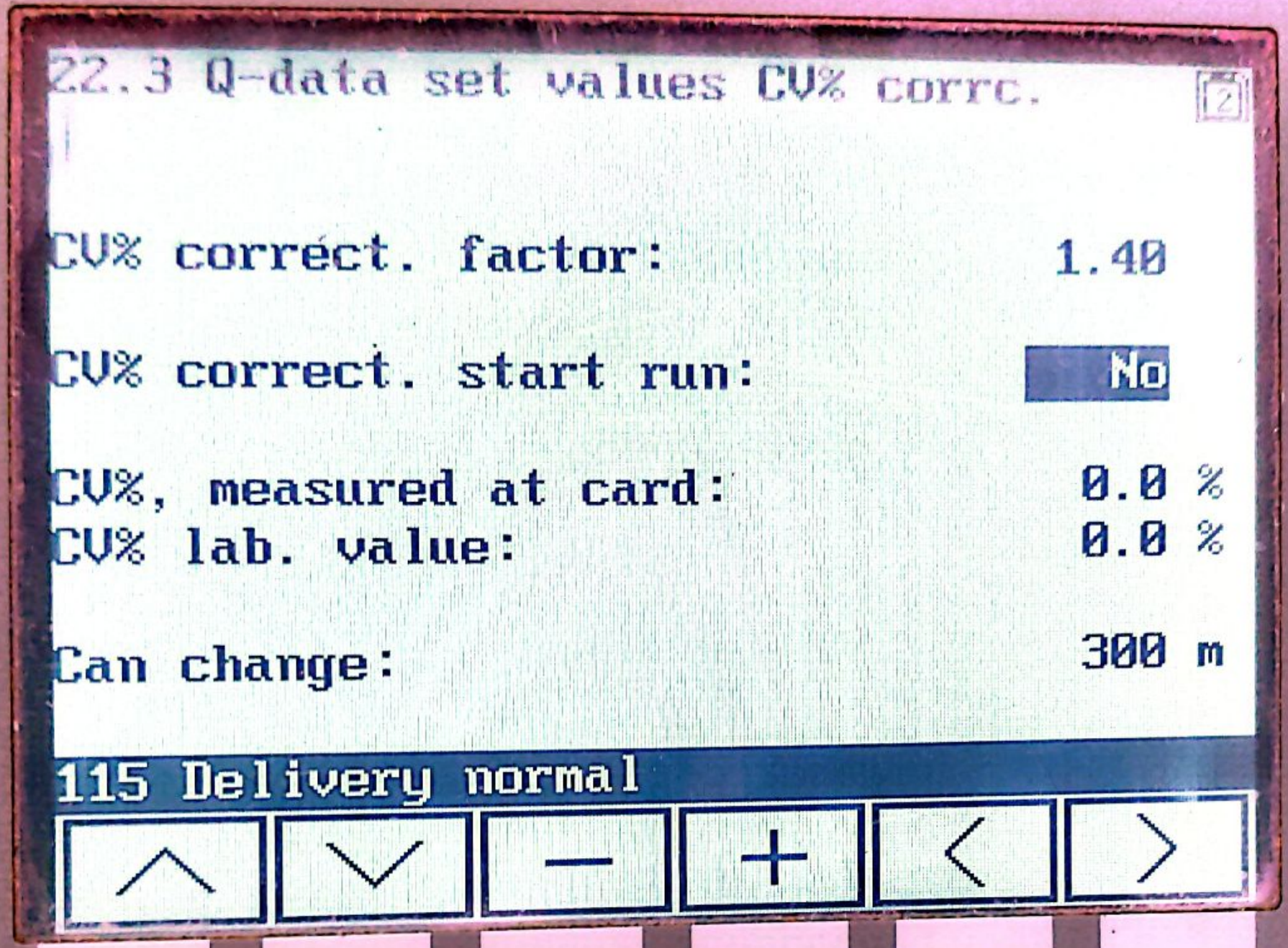

11.34 Prod.act.values work elements ext.
Cylinder
MaxNAend: 9 UnterSetz: 3855
Flat
AktNr: 106
Licker-in
MaxNAend: 198 VrzTroVrsr: 1.8799
115 Delivery normal

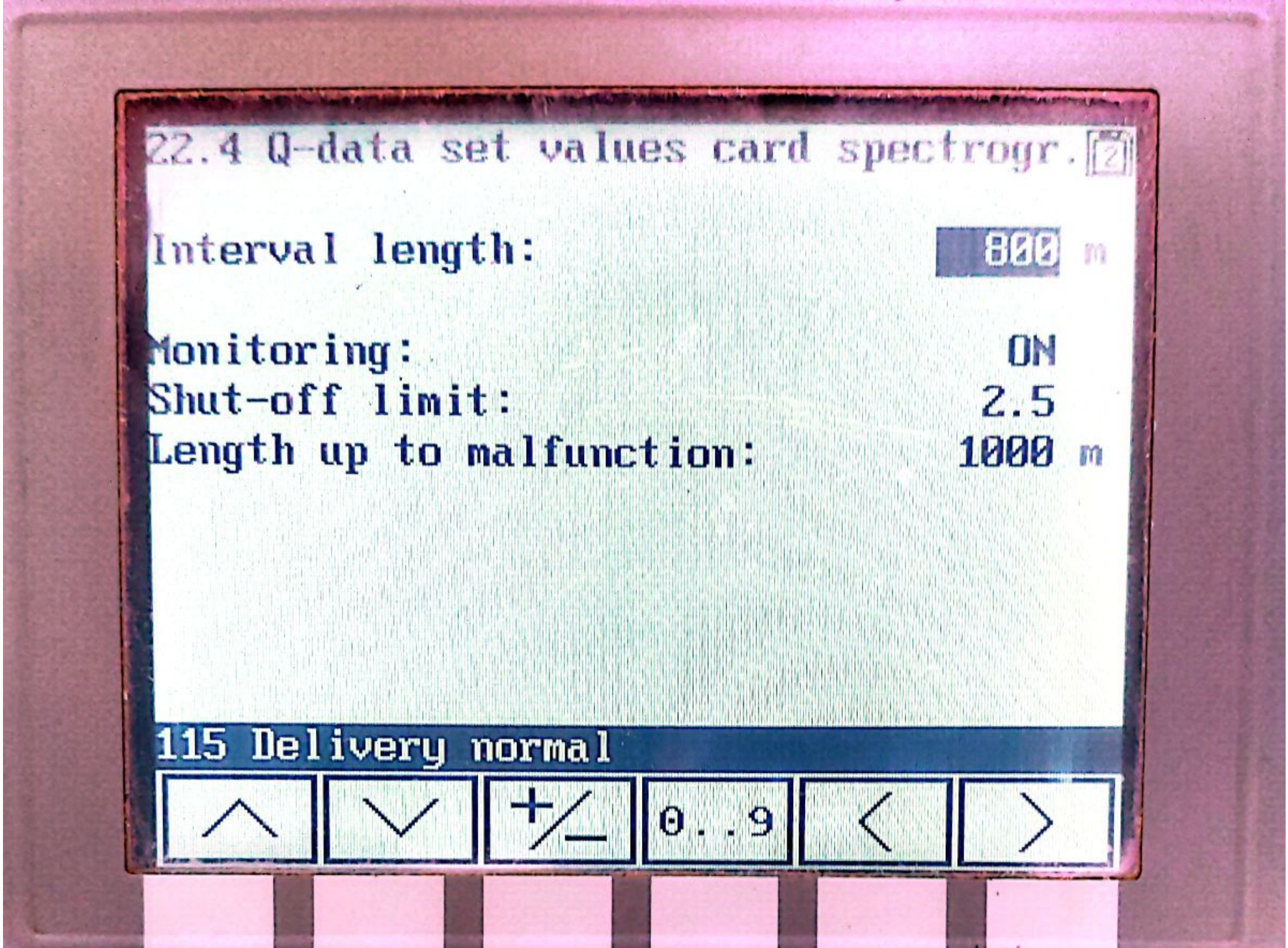

12.1 Production current shift
Current shift: 1
Production efficiency: 100.0 %
Normal production time: 0:01 h
Sliver produced: 4 kg
Number of standstills: 0
Number of can changes: 0
115 Delivery normal

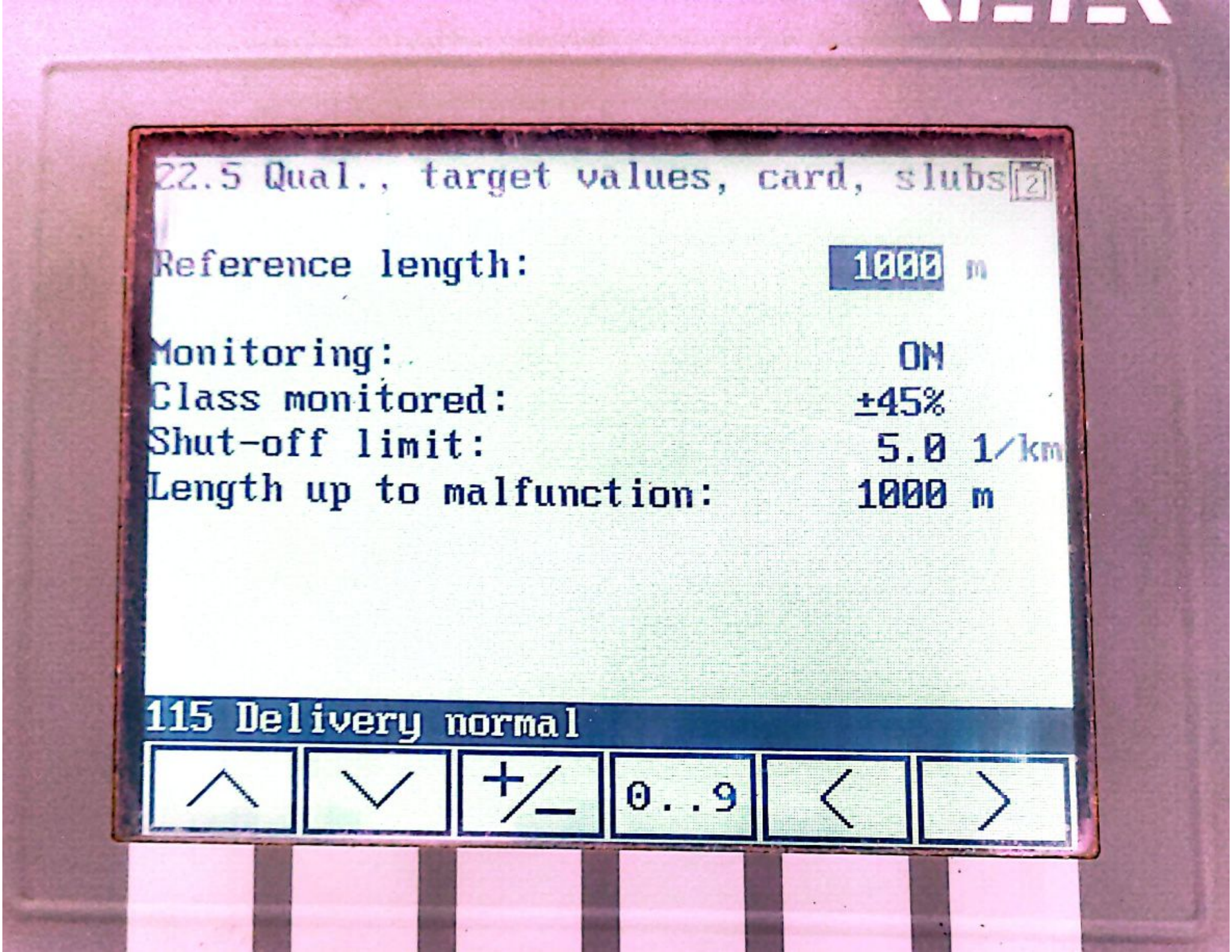

12.6 Delete shifts
Delete shift(s):
No
115 Delivery normal

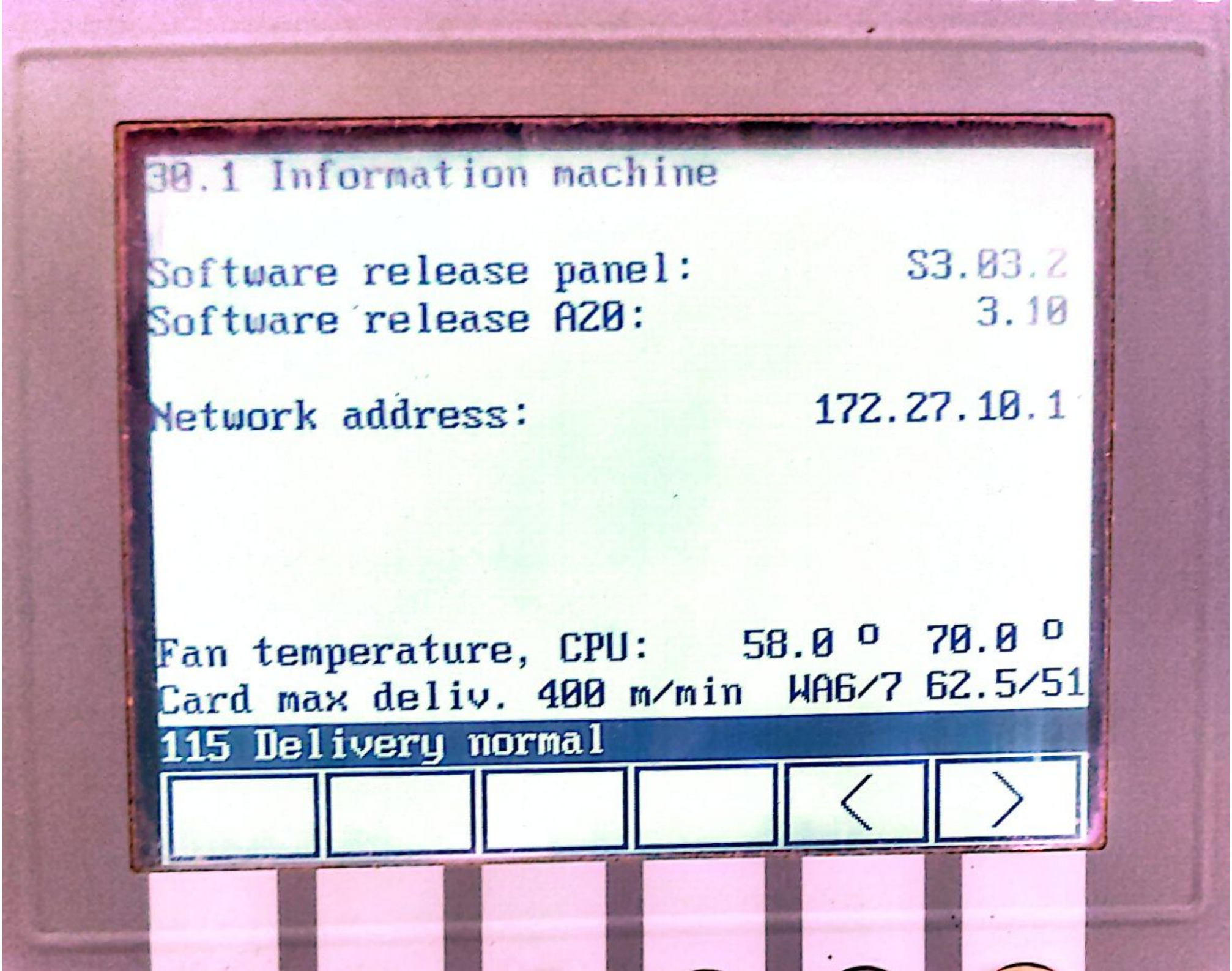

22.1 Q-data set values card A%
2
Measured length:
100 m
Monitoring:
ON
Shut-off limit:
5.0 %
Length up to malfunction:
1000 m
115 Delivery normal
+/_
0..9

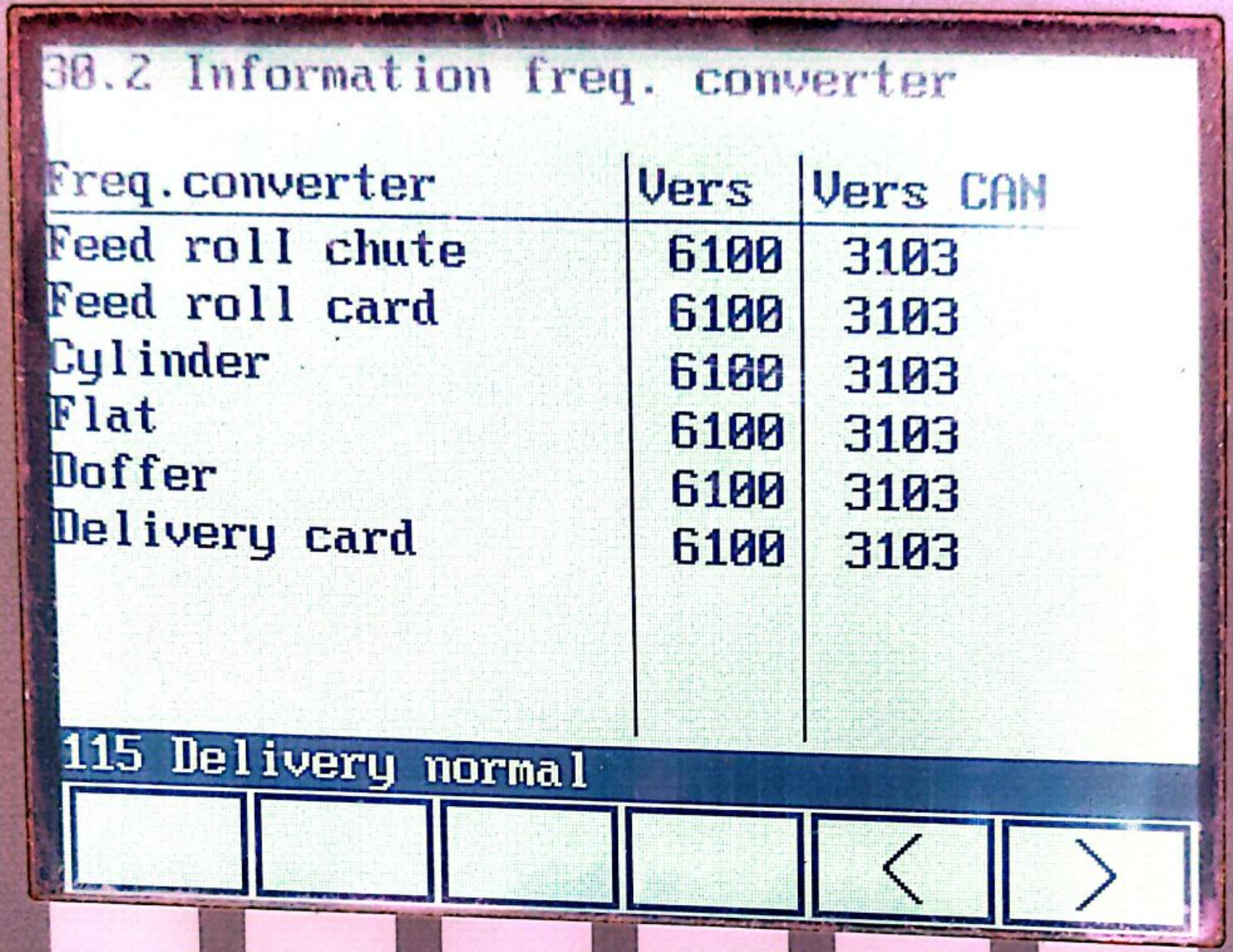

22.2 Q-data set values card CV%
2
Reference length:
3000 m
Monitoring:
ON
Cutting length monitored:
CV100
Shut-off limit:
5.0 %
Length up to malfunction:
1000 m
115 Delivery normal
+/_
0..9

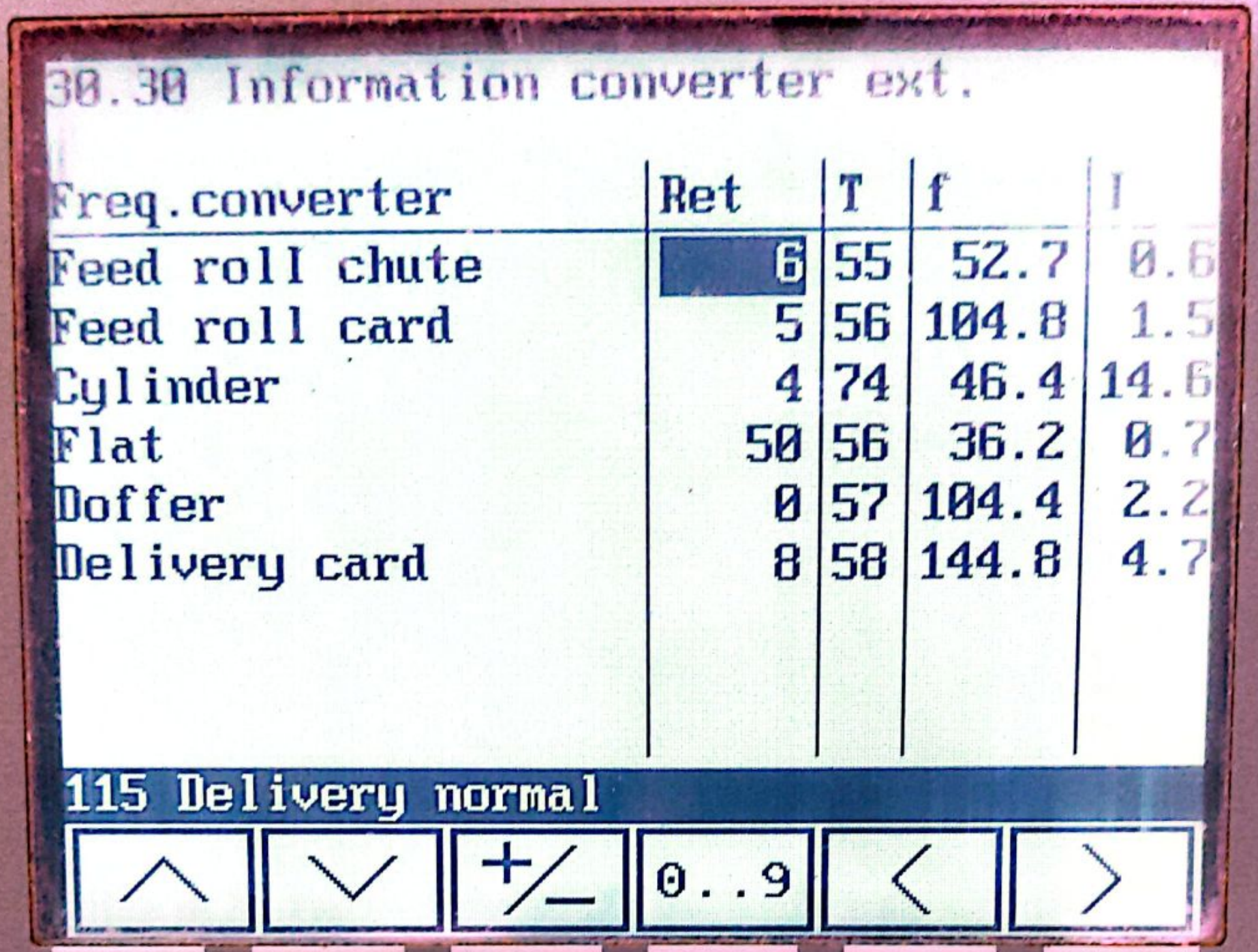

22.3 Q-data set values CV% corrc.
CV% corréct. factor: 1.40
CV% correct. start run: No
CV%, measured at card: 0.0 %
CV% lab. value: 0.0 %
Can change: 300 m
115 Delivery normal

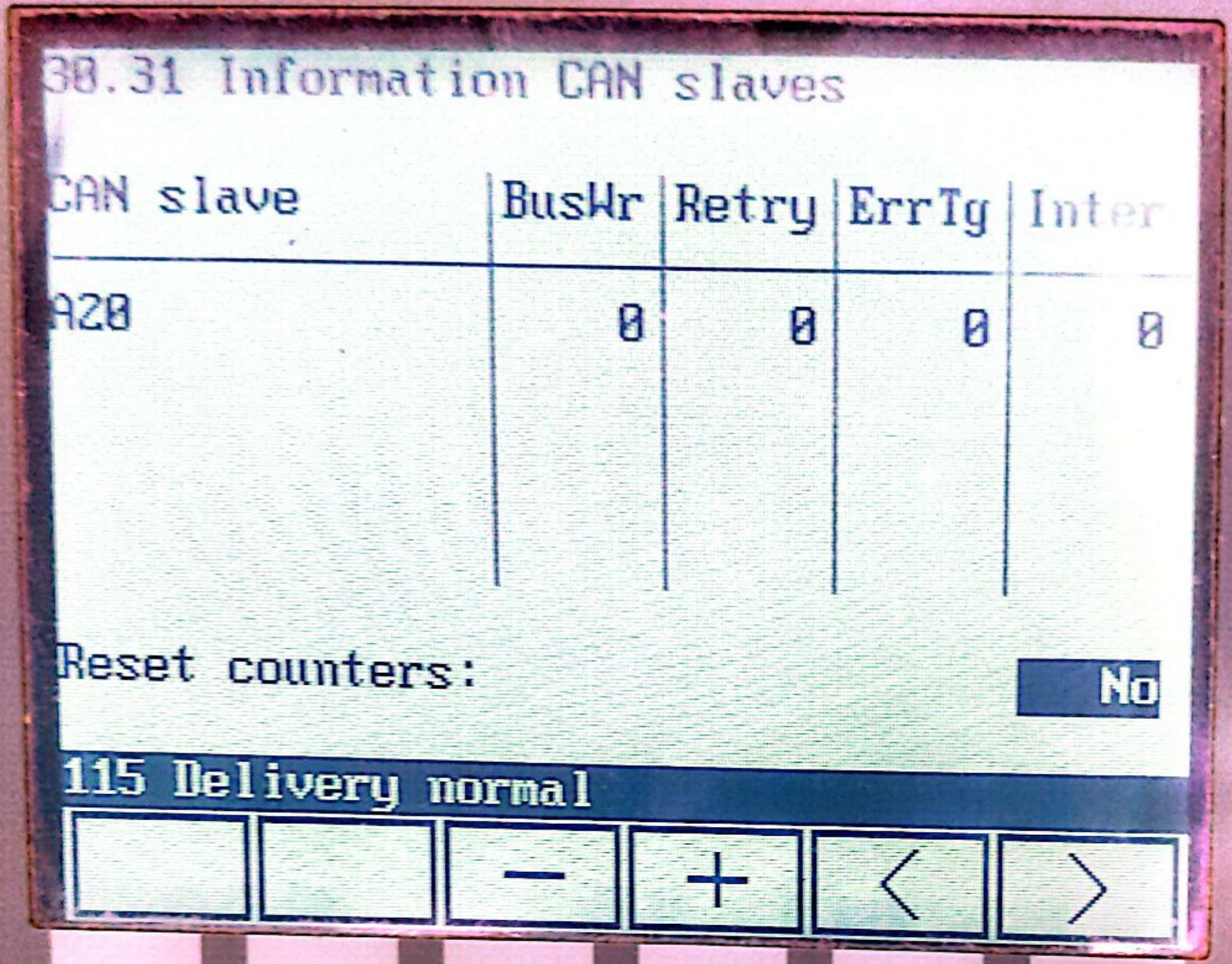

22.4 Q-data set values card spectrogr.
Interval length:
800 m
Monitoring:
ON
Shut-off limit:
2.5
Length up to malfunction:
1000 m
115 Delivery normal
+/-
0..9

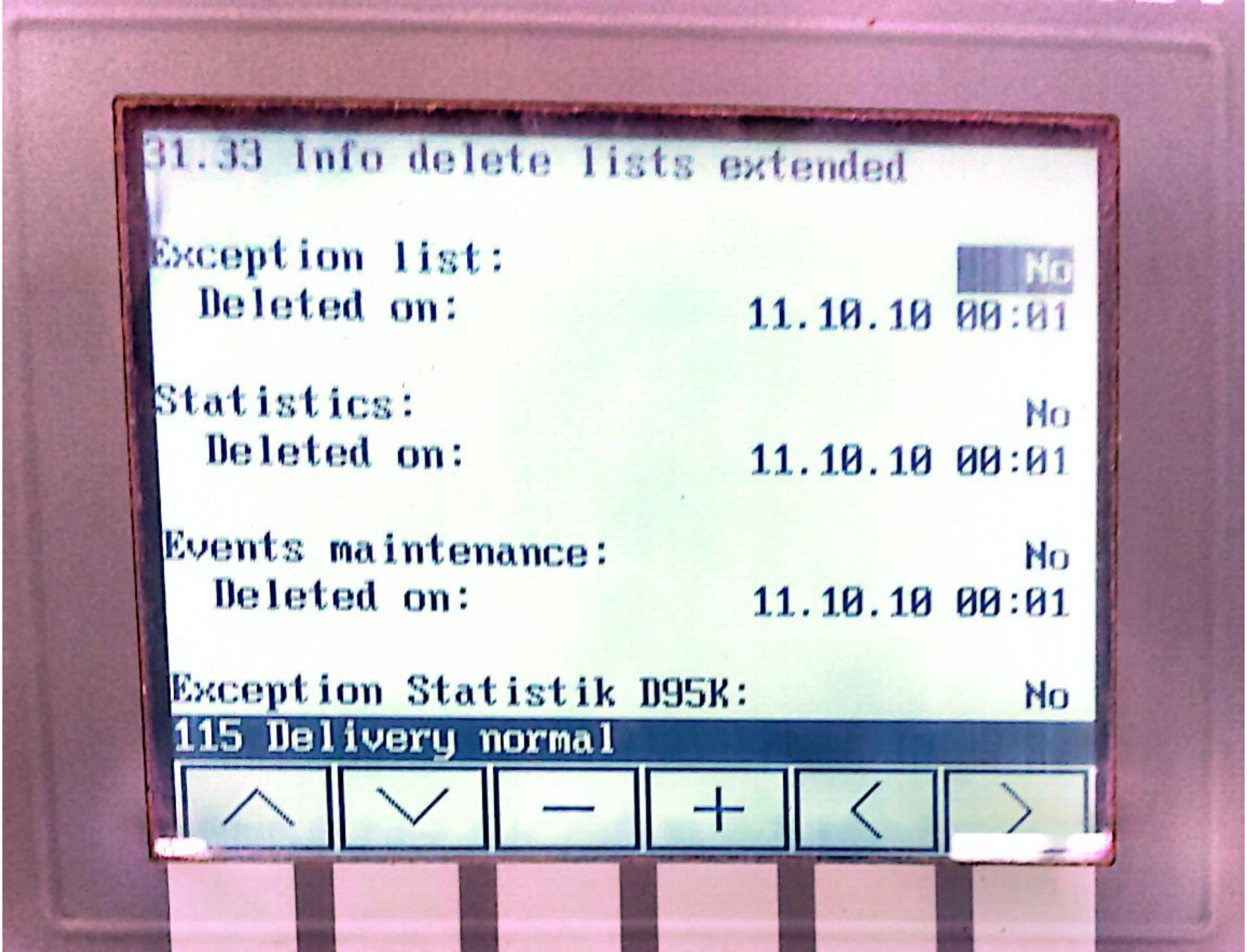

22.5 Qual., target values, card, slubs
2
Reference length: 1000 m
Monitoring: ON
Class monitored: ±45%
Shut-off limit: 5.0 1/km
Length up to malfunction: 1000 m
115 Delivery normal
+/_
0..9

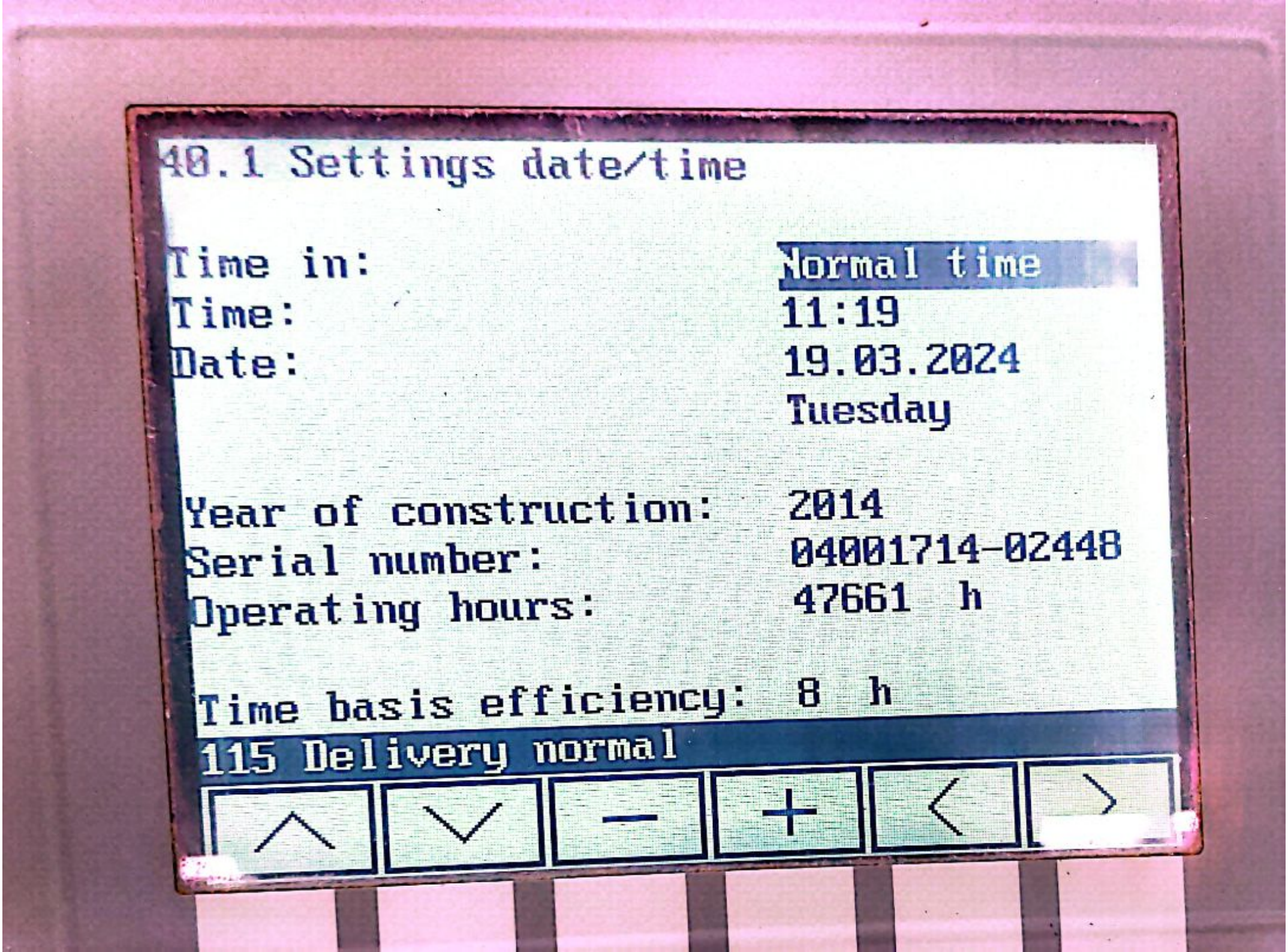

30.1 Information machine
Software release panel: S3.03.2
Software release A20: 3.10
Network address: 172.27.10.1
Fan temperature, CPU: 58.0 o 70.0 o
Card max deliv. 400 m/min WA6/7 62.5/51
115 Delivery normal

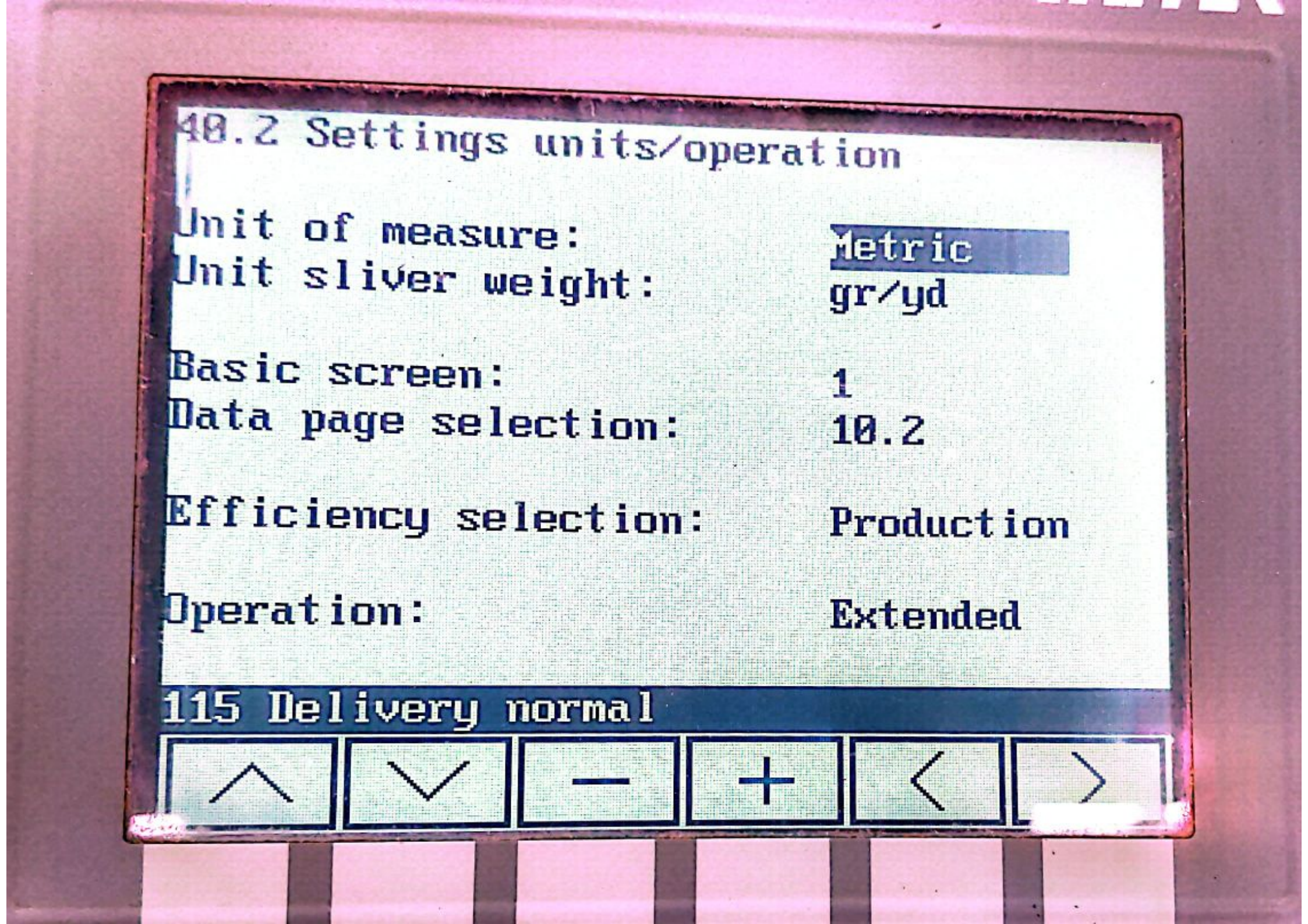

30.2 Information freq. converter
Freq.converter | Vers | Vers CAN
Feed roll chute | 6100 | 3103
Feed roll card | 6100 | 3103
Cylinder | 6100 | 3103
Flat | 6100 | 3103
Doffer | 6100 | 3103
Delivery card | 6100 | 3103
115 Delivery normal

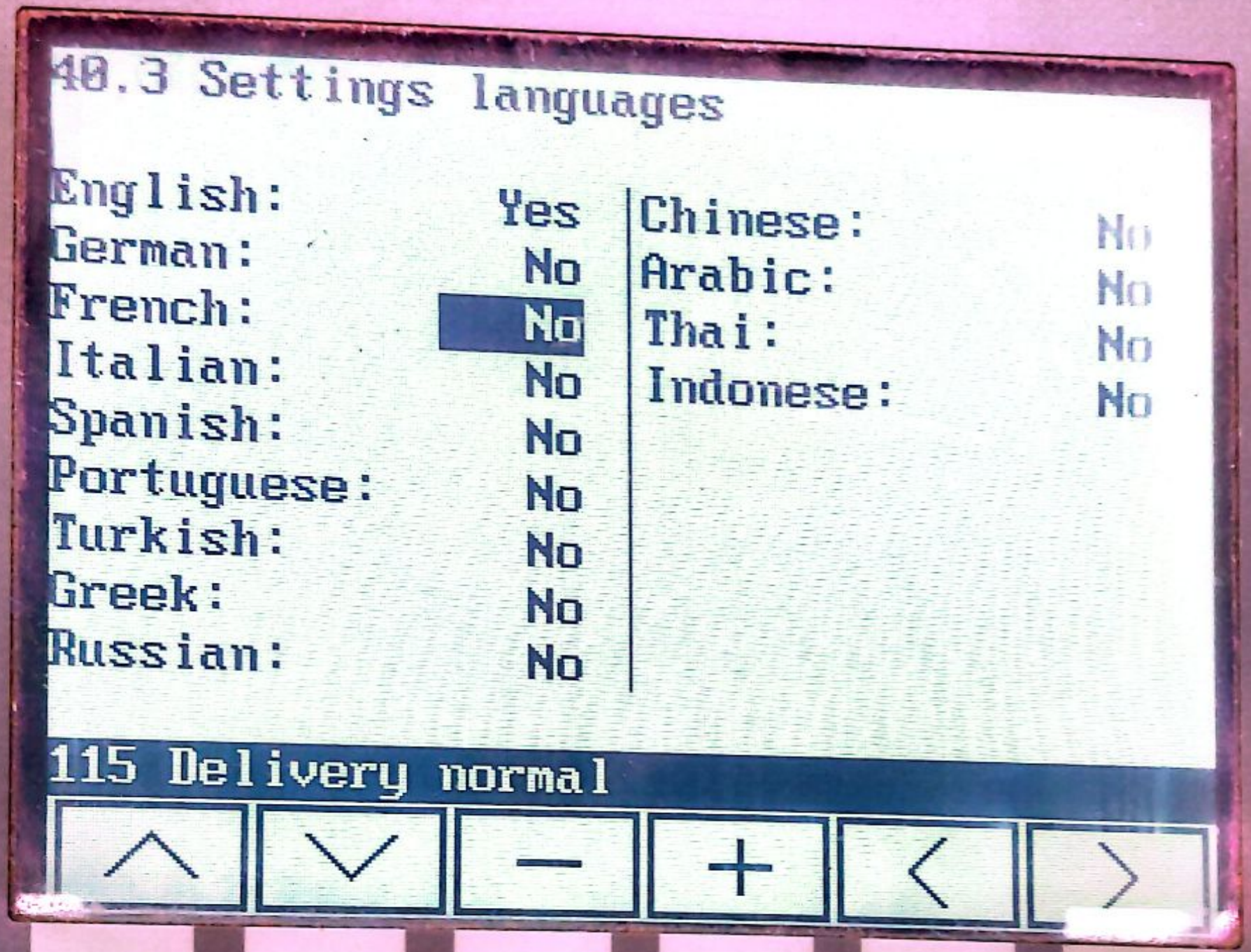

30.30 Information converter ext.
Freq.converter
Ret
T
f
I
Feed roll chute 6 55 52.7 0.6
Feed roll card 5 56 104.8 1.5
Cylinder 4 74 46.4 14.6
Flat 50 56 36.2 0.7
Doffer 0 57 104.4 2.2
Delivery card 8 58 144.8 4.7
115 Delivery normal
+/_
0..9

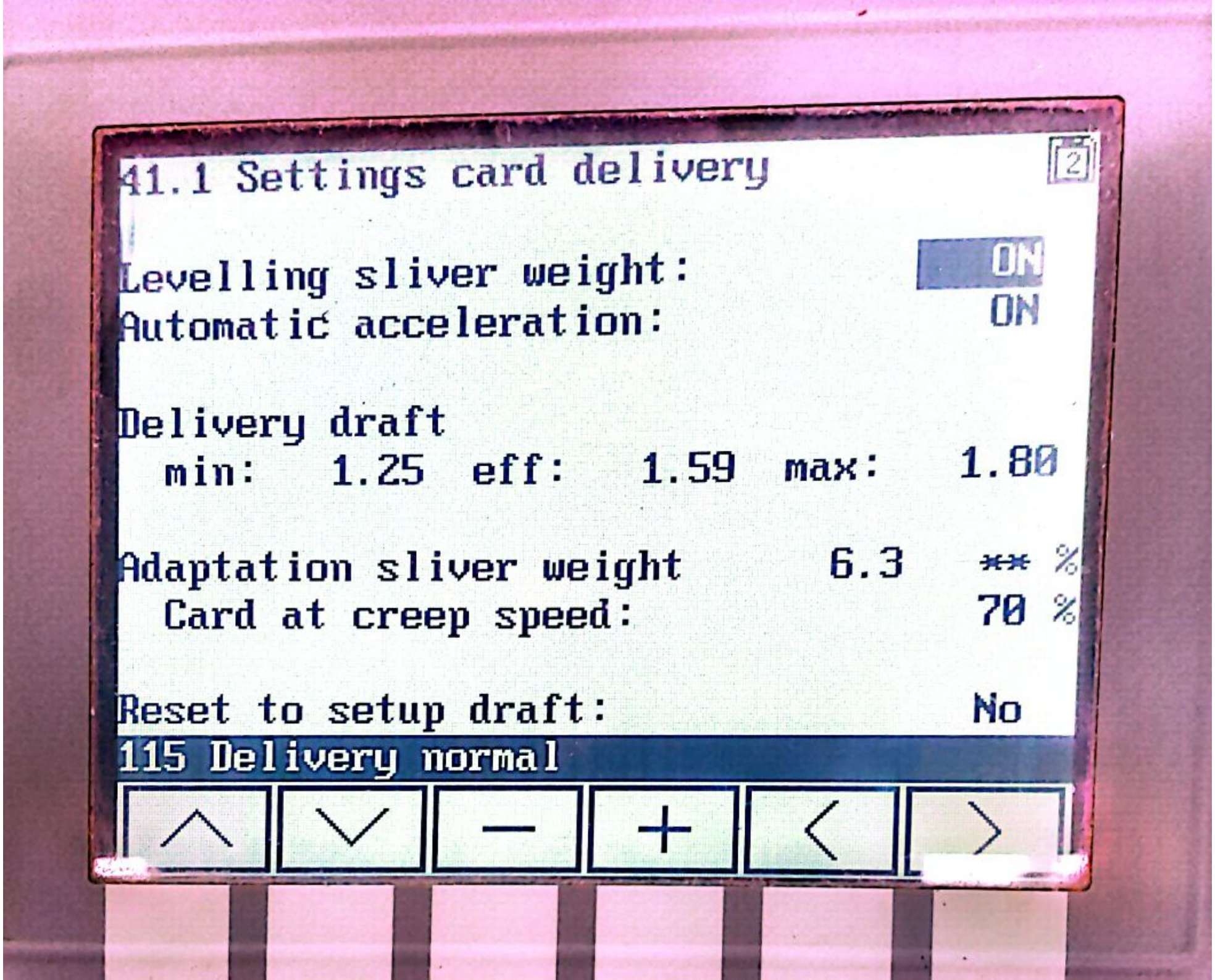

30.31 Information CAN slaves
CAN slave
BusWr
Retry
ErrTg
Inter
A20
0
0
0
0
Reset counters:
No
115 Delivery normal

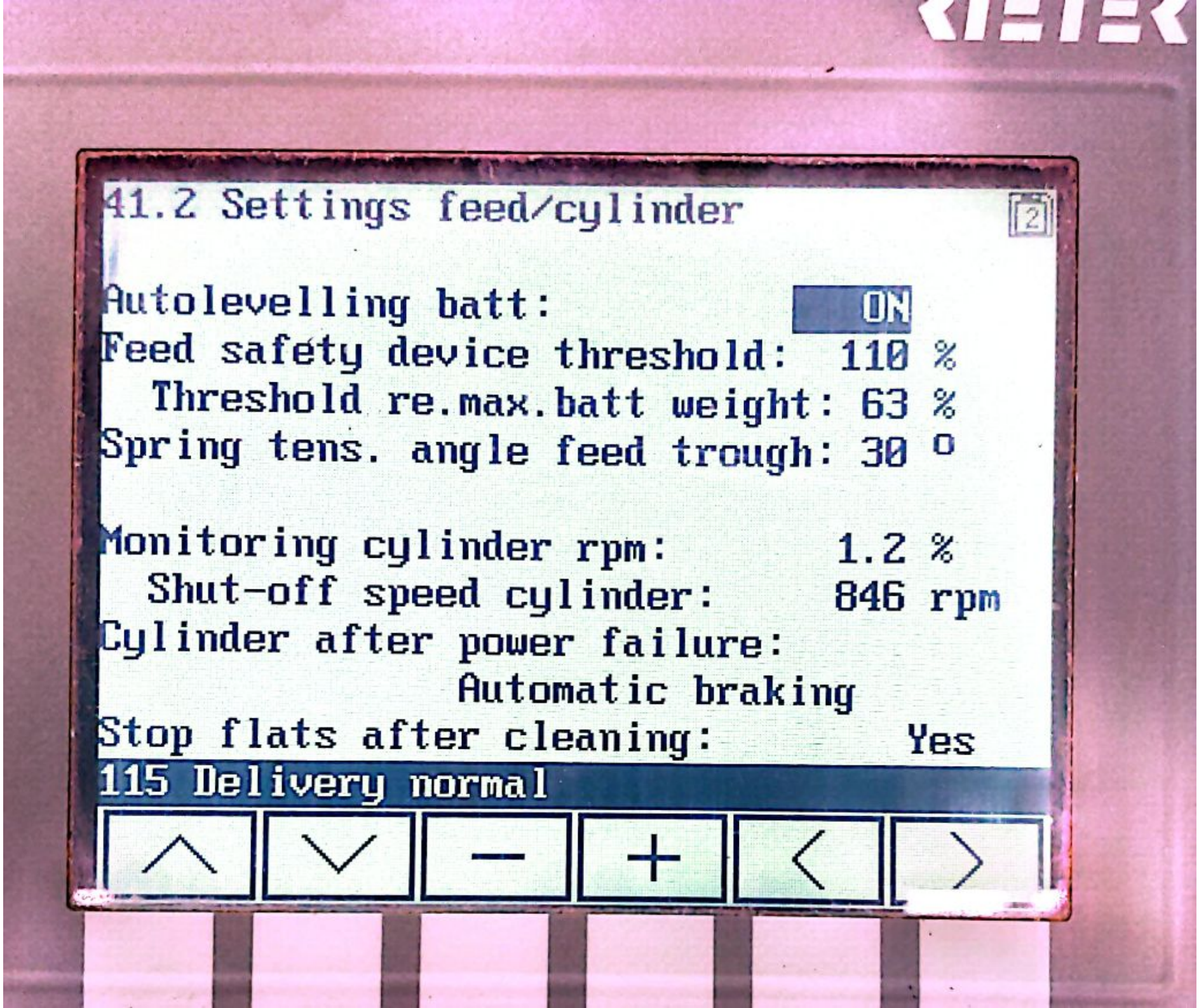

31.33 Info delete lists extended
Exception list:
No
Deleted on:
11.10.10 00:01
Statistics:
No
Deleted on:
11.10.10 00:01
Events maintenance:
No
Deleted on:
11.10.10 00:01
Exception Statistik D95K:
No
115 Delivery normal

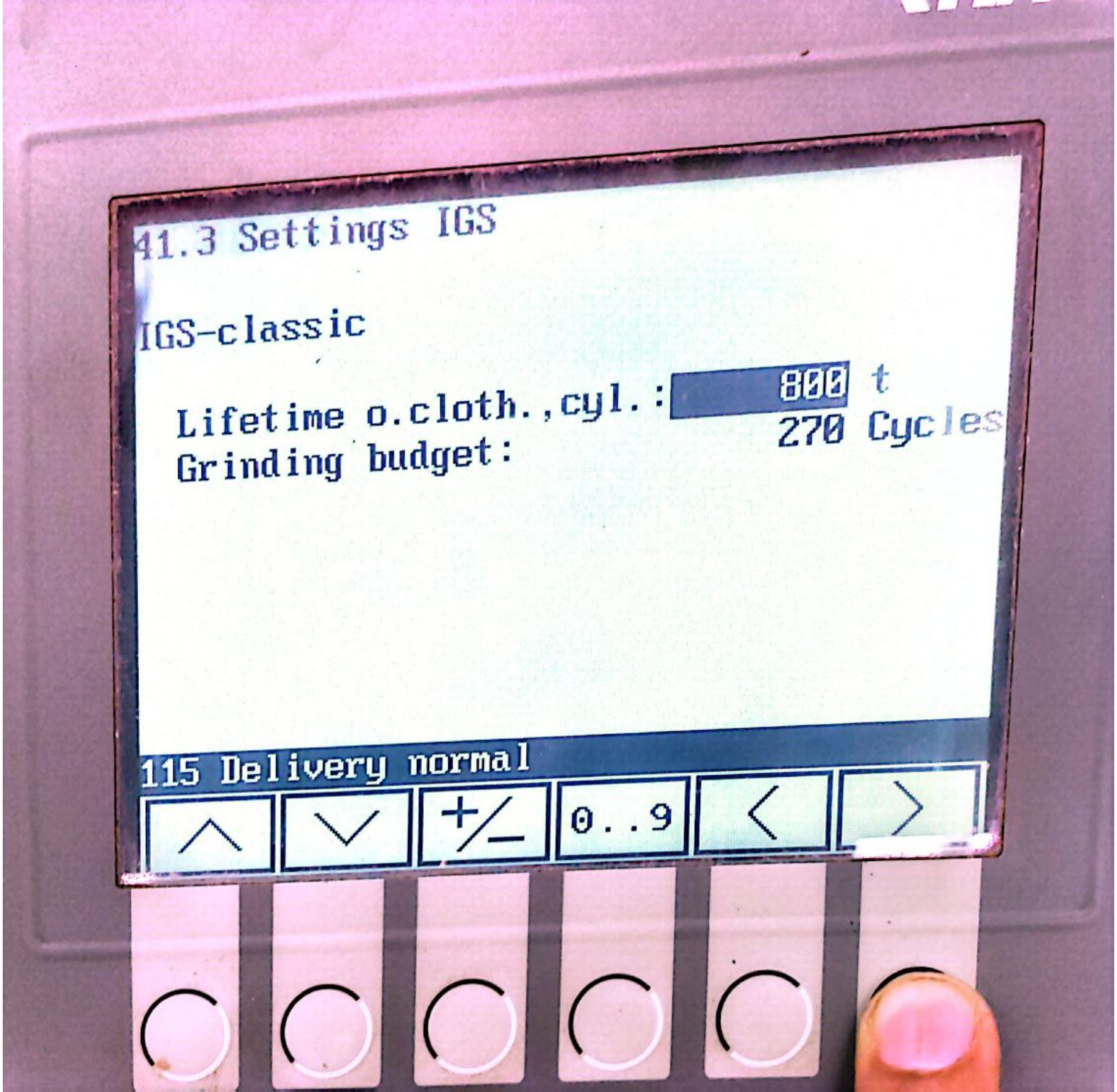

40.1 Settings date/time
Time in: Normal time
Time: 11:19
Date: 19.03.2024
Tuesday
Year of construction: 2014
Serial number: 04001714-02448
Operating hours: 47661 h
Time basis efficiency: 8 h
115 Delivery normal

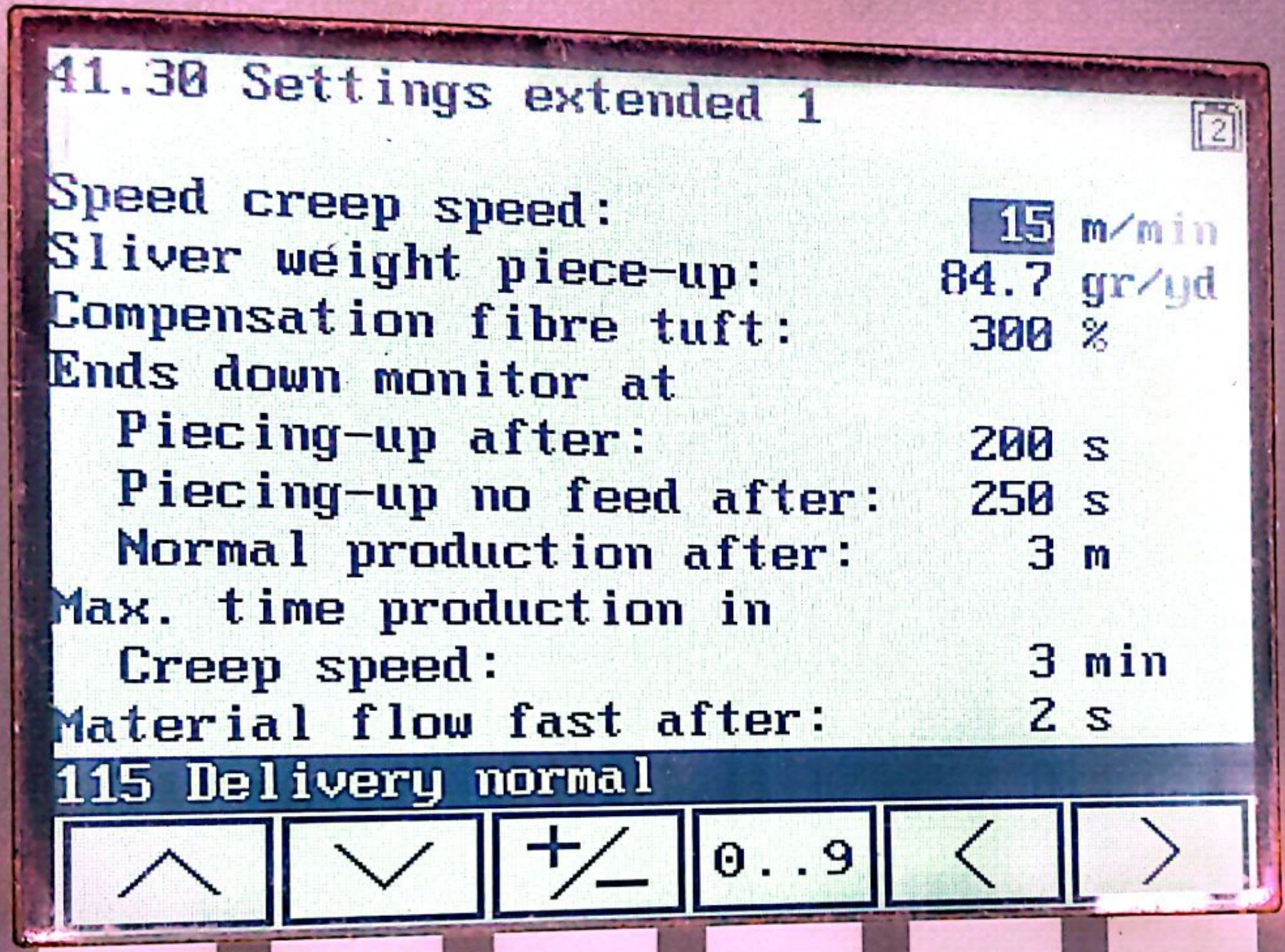

40.2 Settings units/operation
Unit of measure:
Metric
Unit sliver weight:
gr/yd
Basic screen:
1
Data page selection:
10.2
Efficiency selection:
Production
Operation:
Extended
115 Delivery normal

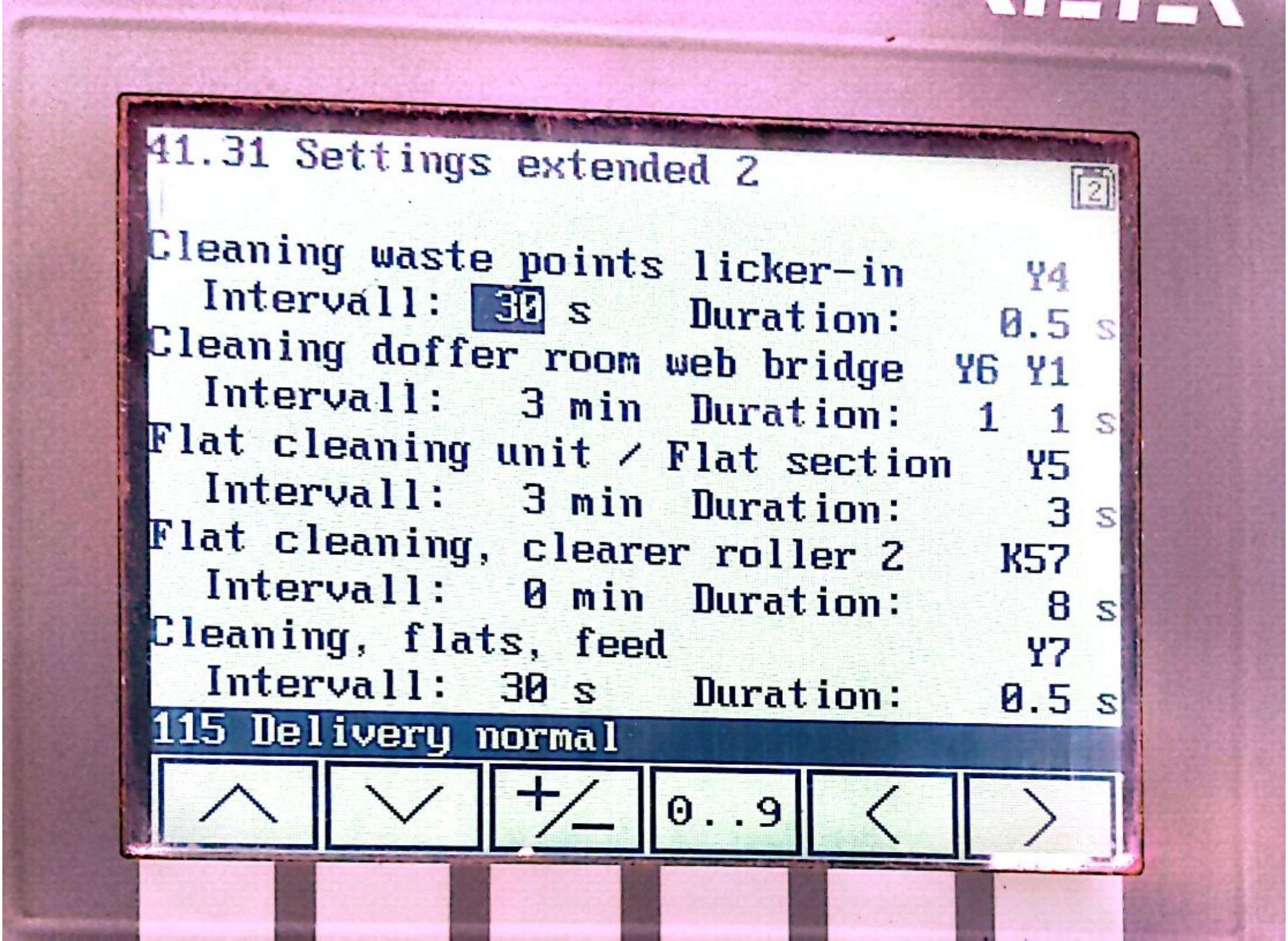

40.3 Settings languages
English: Yes
German: No
French: No
Italian: No
Spanish: No
Portuguese: No
Turkish: No
Greek: No
Russian: No
Chinese: No
Arabic: No
Thai: No
Indonese: No
115 Delivery normal

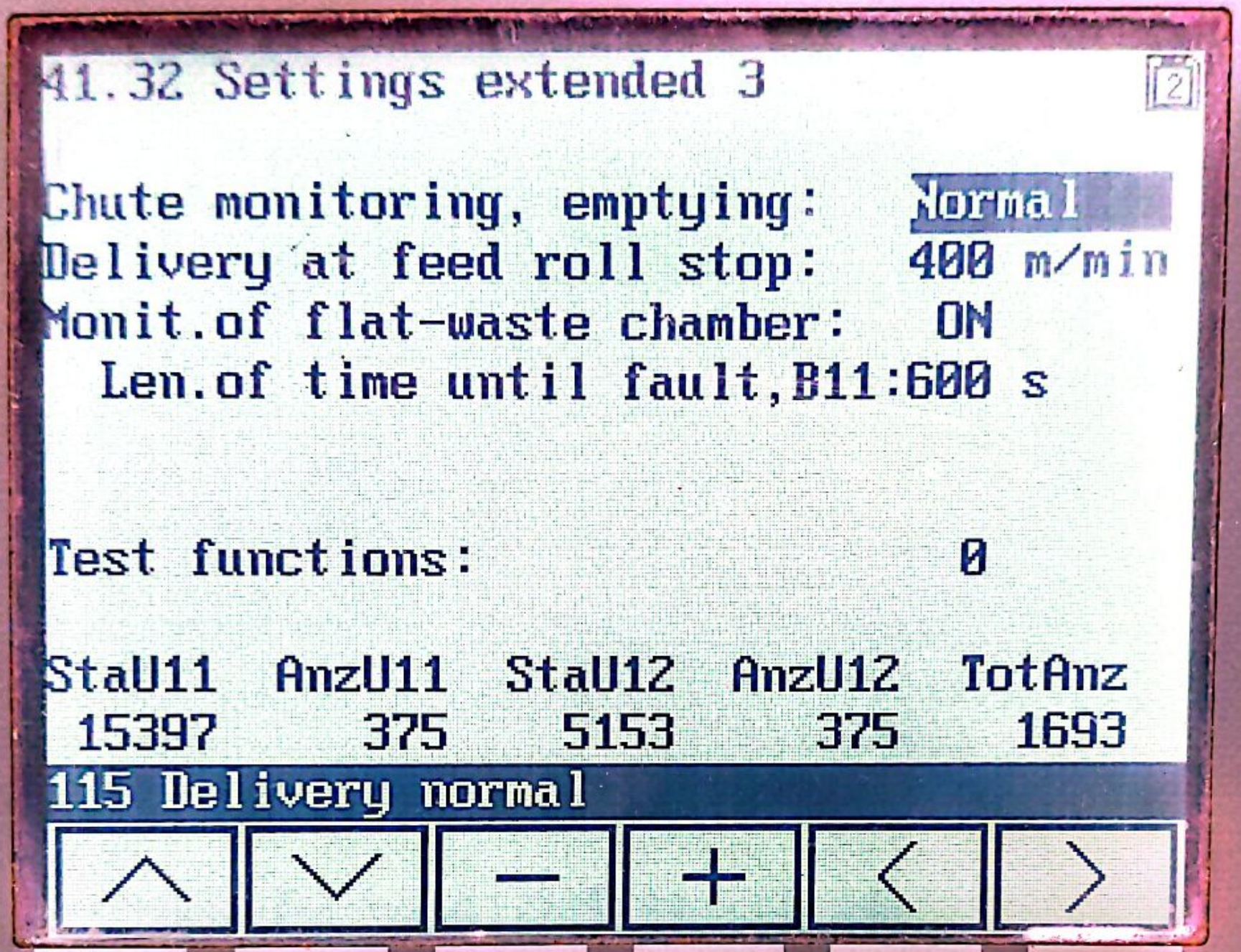

41.1 Settings card delivery
2
Levelling sliver weight: ON
Automatic acceleration: ON
Delivery draft
min: 1.25 eff: 1.59 max: 1.80
Adaptation sliver weight 6.3 ** %
Card at creep speed: 70 %
Reset to setup draft: No
115 Delivery normal

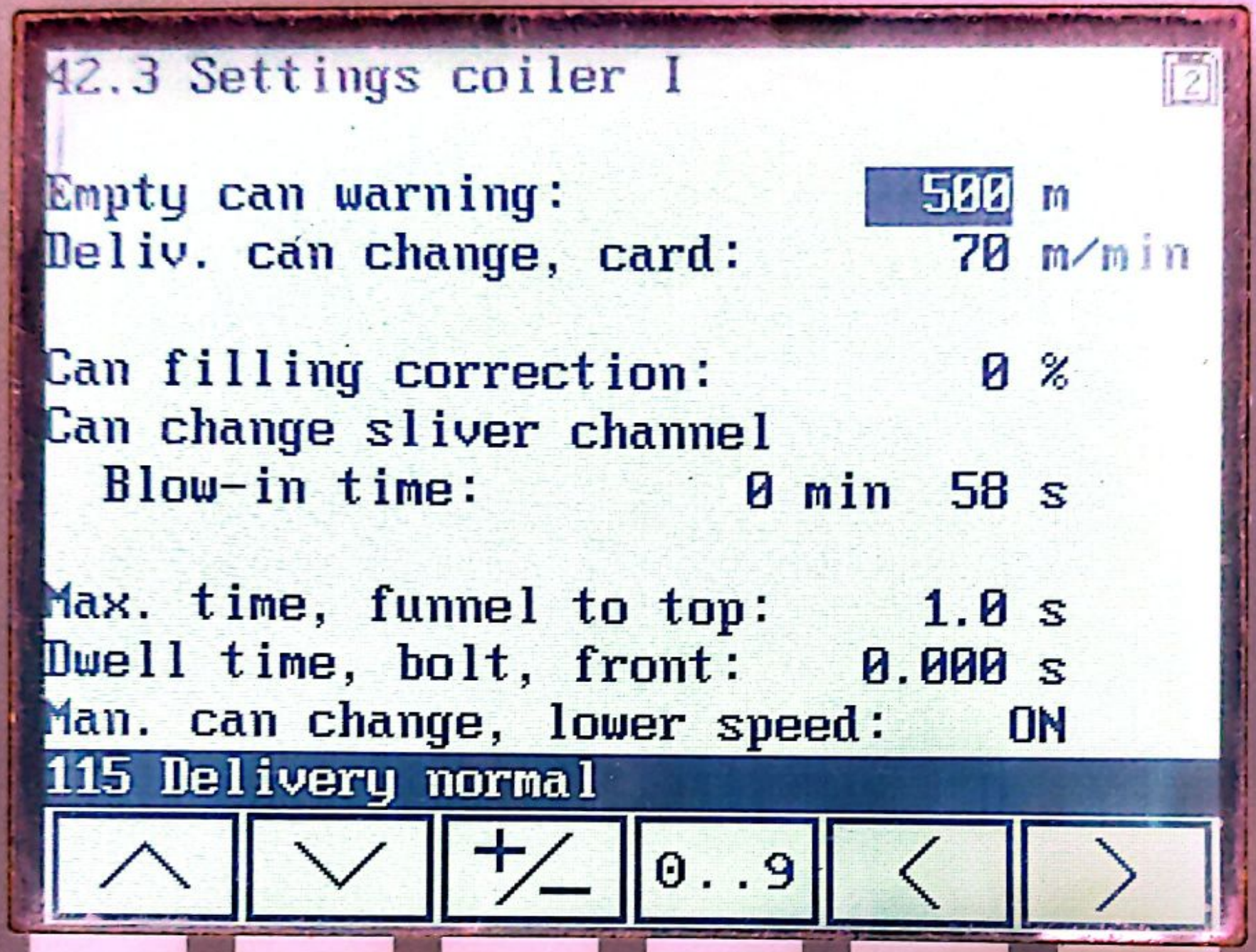

41.2 Settings feed/cylinder
2
Autolevelling batt: ON
Feed safety device threshold: 110 %
Threshold re.max.batt weight: 63 %
Spring tens. angle feed trough: 30 °
Monitoring cylinder rpm: 1.2 %
Shut-off speed cylinder: 846 rpm
Cylinder after power failure:
Automatic braking
Stop flats after cleaning: Yes
115 Delivery normal

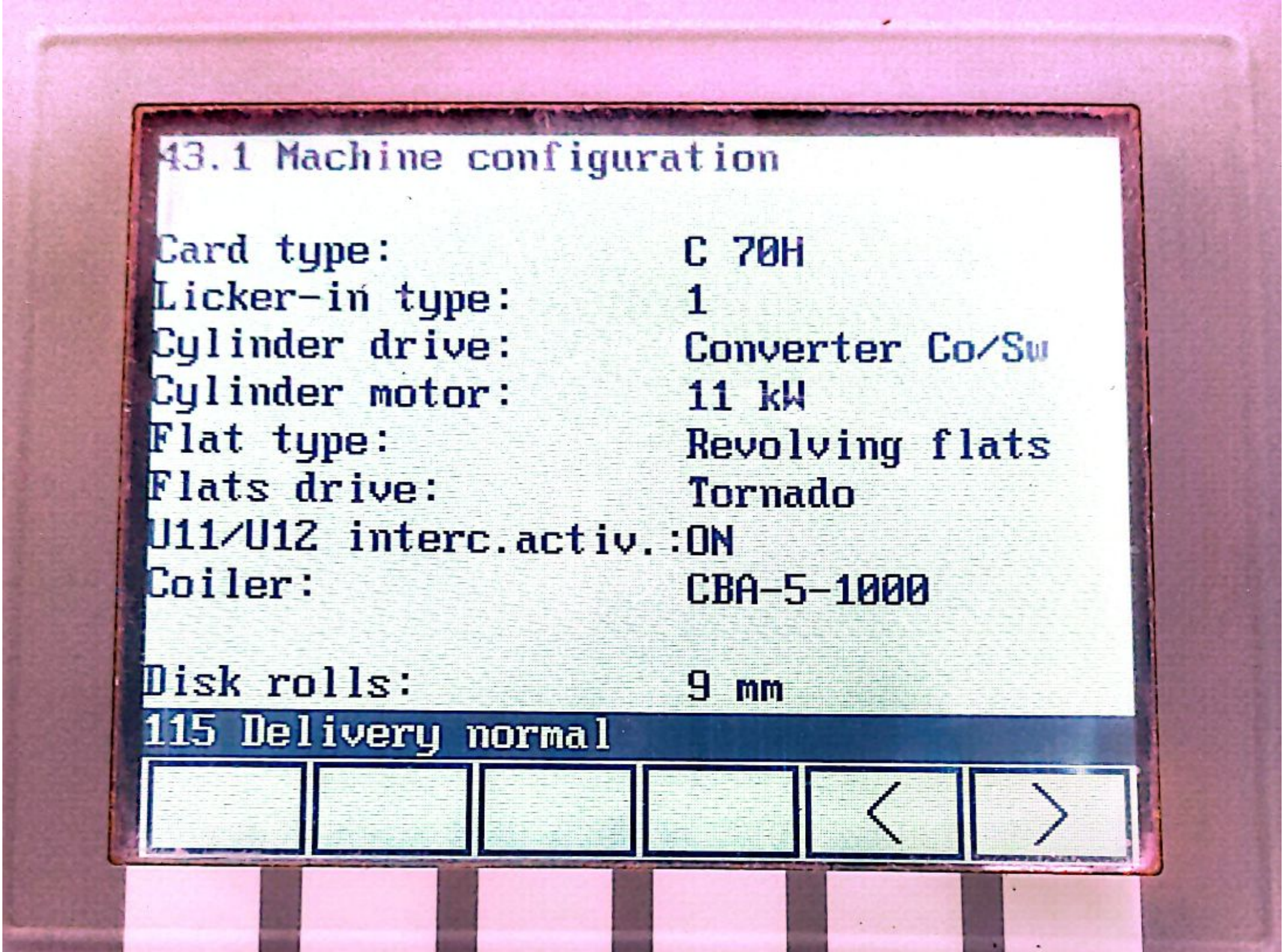

41.3 Settings IGS
IGS-classic
Lifetime o.cloth.,cyl.: 800 t
Grinding budget: 270 Cycles
115 Delivery normal
+/-
0..9

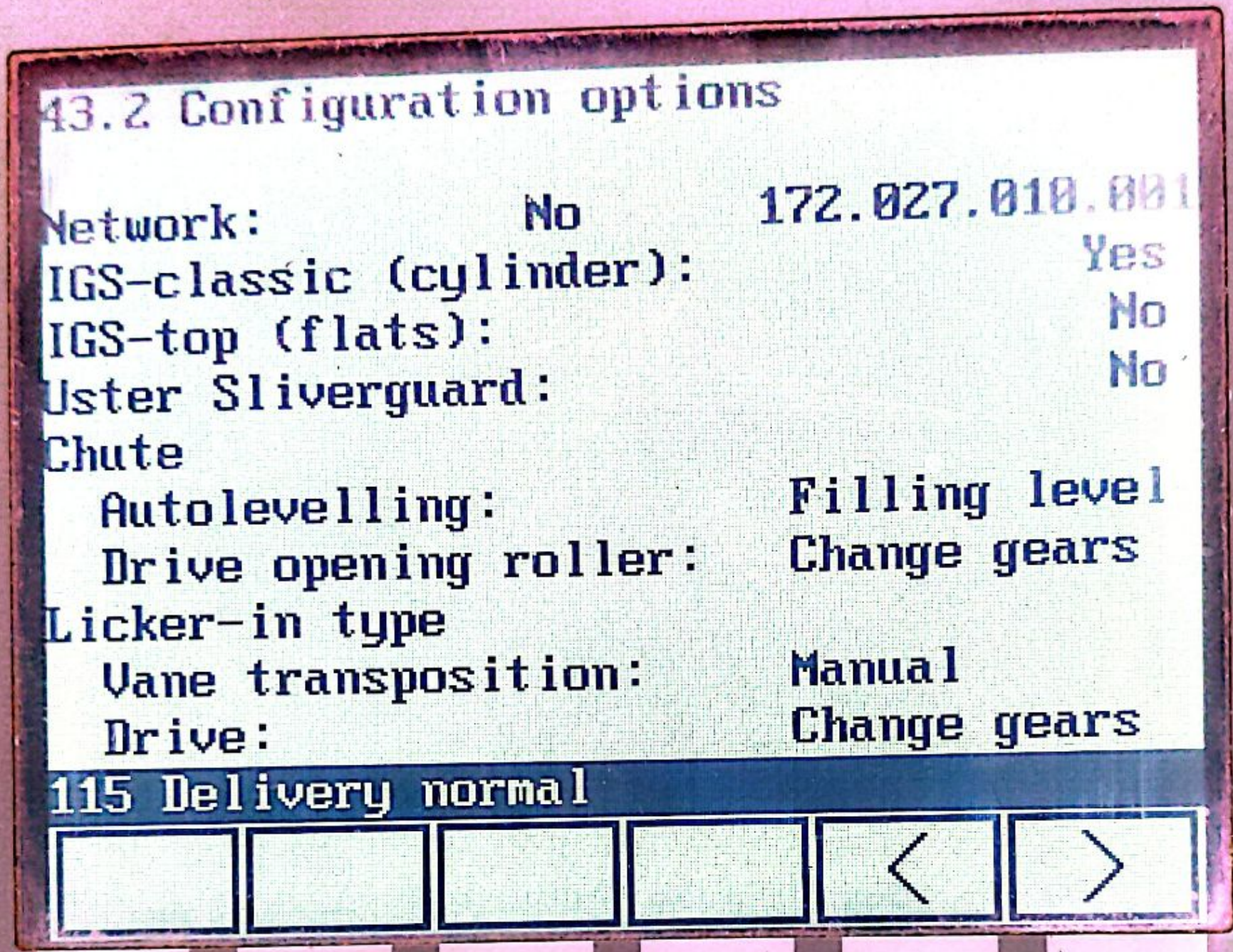

41.30 Settings extended 1
2
Speed creep speed: 15 m/min
Sliver weight piece-up: 84.7 gr/yd
Compensation fibre tuft: 300 %
Ends down monitor at
Piecing-up after: 200 s
Piecing-up no feed after: 250 s
Normal production after: 3 m
Max. time production in
Creep speed: 3 min
Material flow fast after: 2 s
115 Delivery normal
+/_
0..9

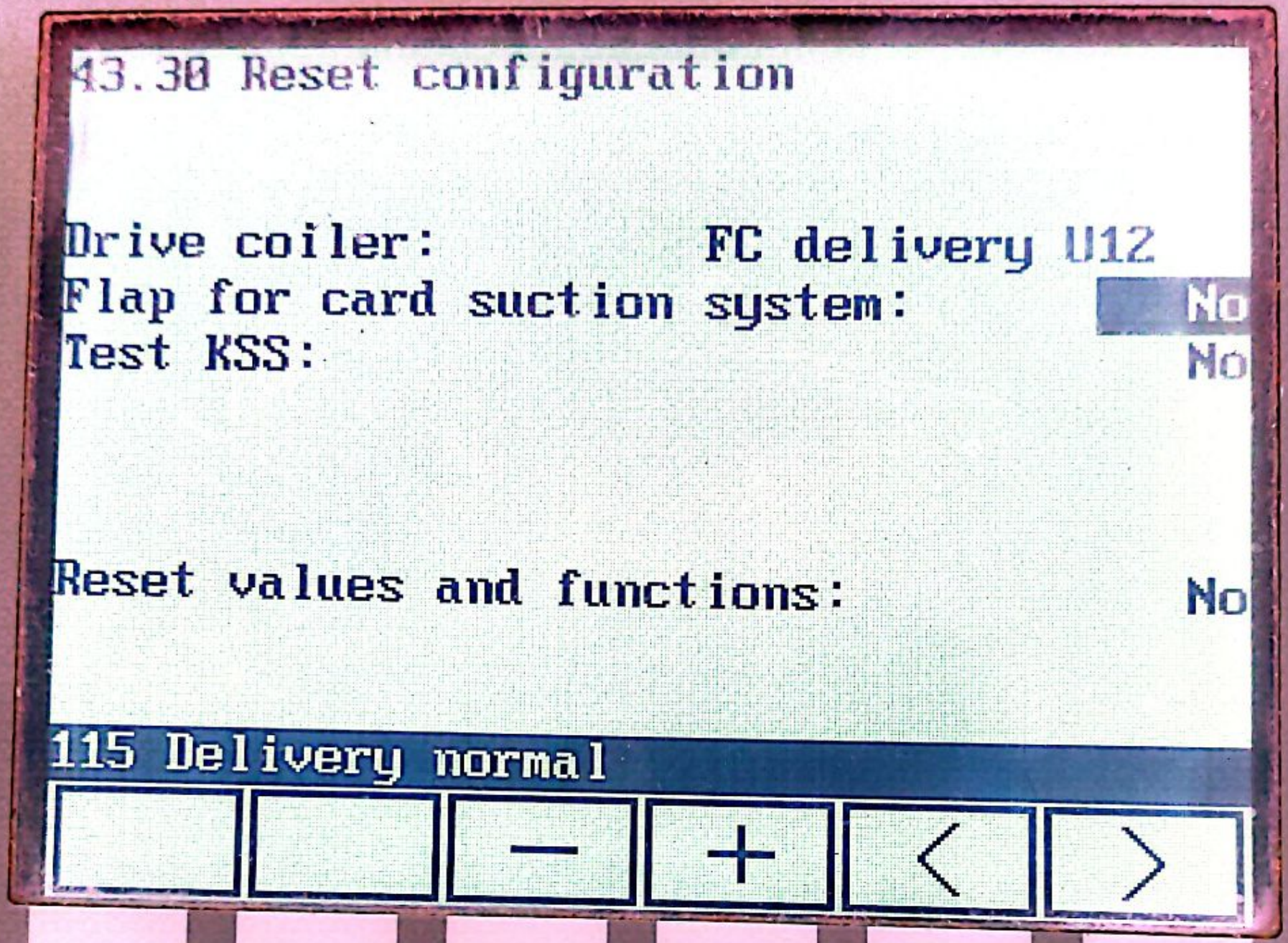

41.31 Settings extended 2
2
Cleaning waste points licker-in Y4
Intervall: 30 s Duration: 0.5 s
Cleaning doffer room web bridge Y6 Y1
Intervall: 3 min Duration: 1 1 s
Flat cleaning unit / Flat section Y5
Intervall: 3 min Duration: 3 s
Flat cleaning, clearer roller 2 K57
Intervall: 0 min Duration: 8 s
Cleaning, flats, feed Y7
Intervall: 30 s Duration: 0.5 s
115 Delivery normal
+/−
0..9

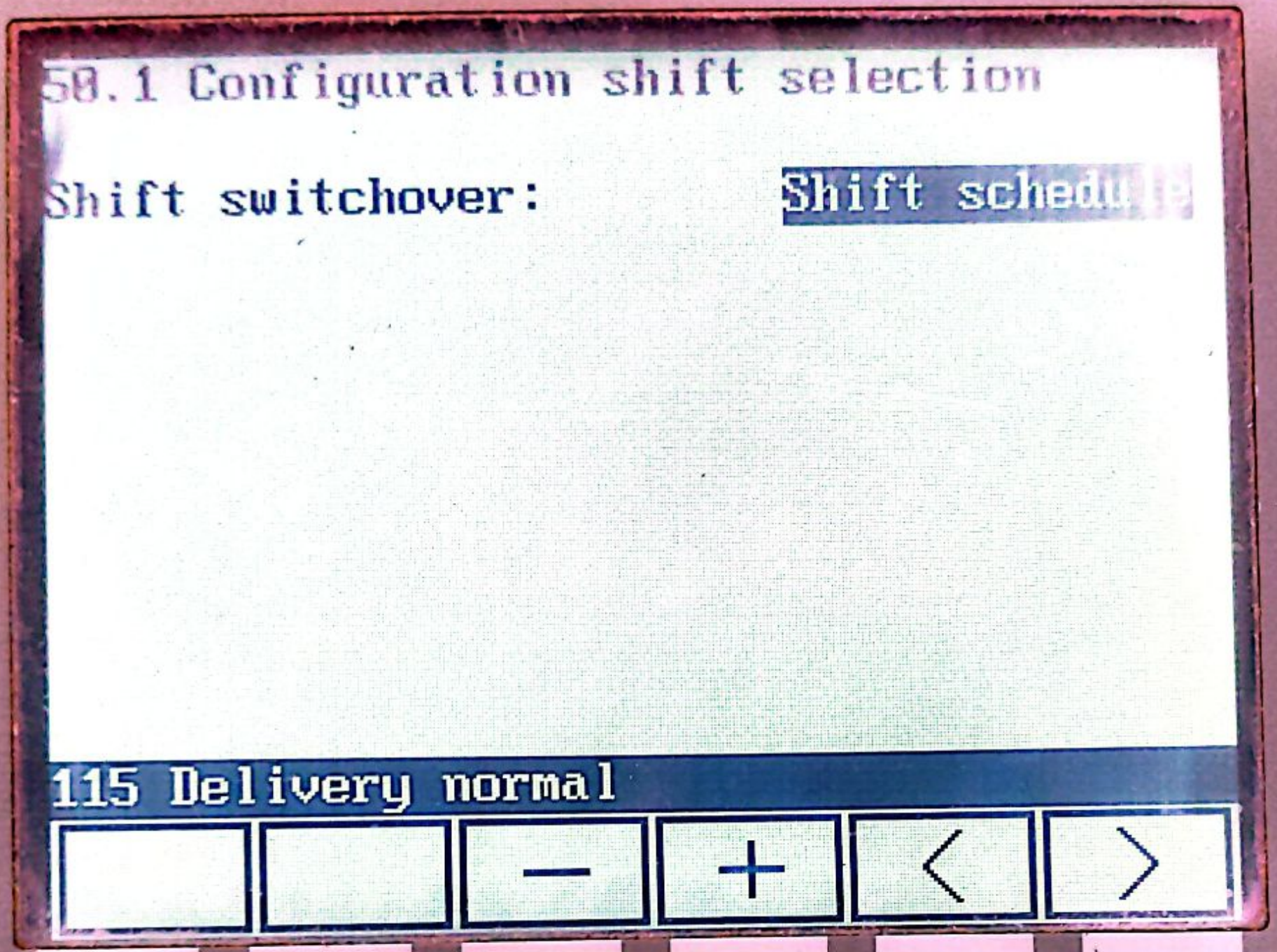

41.32 Settings extended 3
2
Chute monitoring, emptying: Normal
Delivery at feed roll stop: 400 m/min
Monit.of flat-waste chamber: ON
Len.of time until fault,B11:600 s
Test functions: 0
StaU11 AnzU11 StaU12 AnzU12 TotAnz
15397 375 5153 375 1693
115 Delivery normal

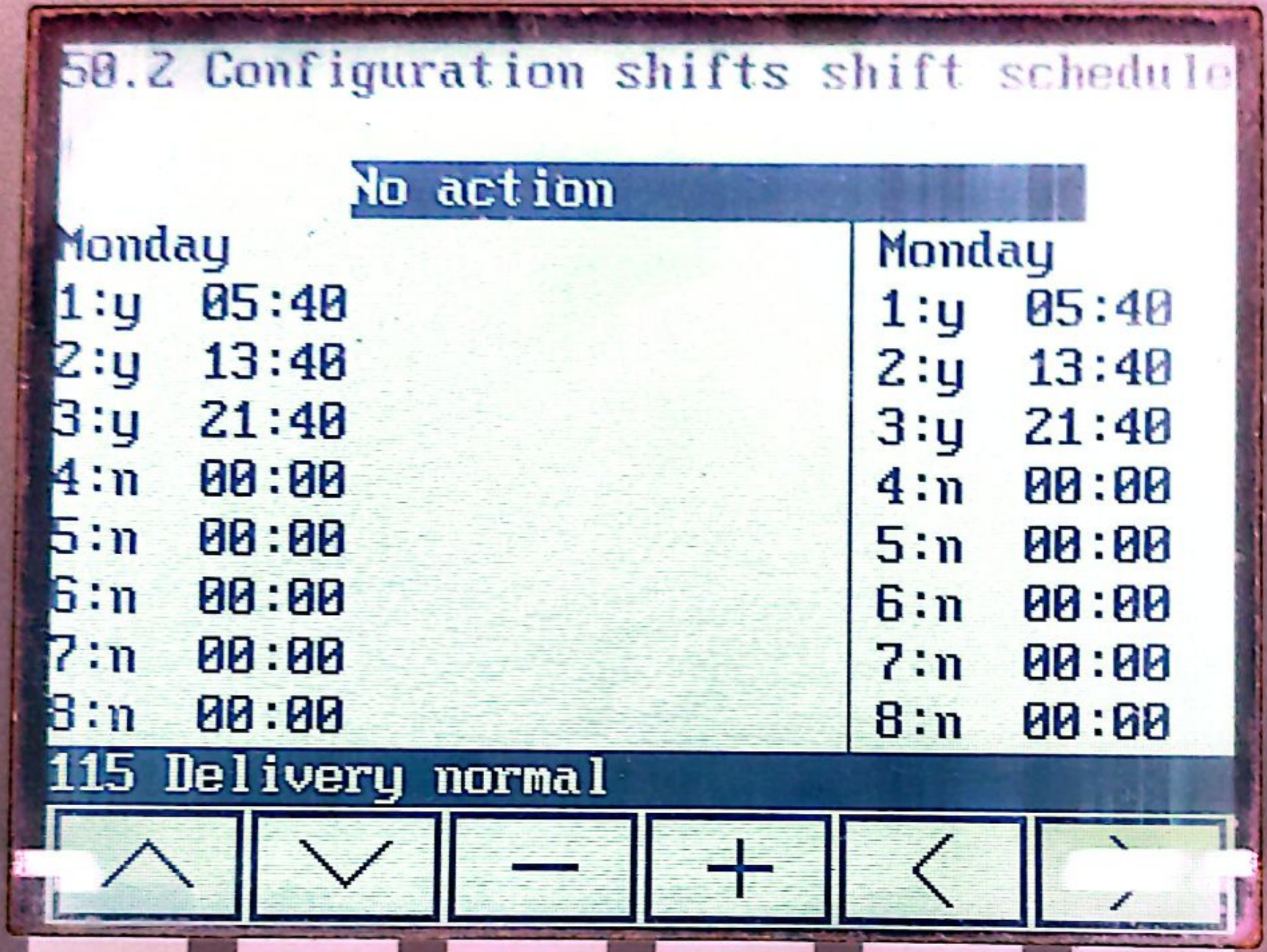

42.3 Settings coiler I
2
Empty can warning: 500 m
Deliv. can change, card: 70 m/min
Can filling correction: 0 %
Can change sliver channel
Blow-in time: 0 min 58 s
Max. time, funnel to top: 1.0 s
Dwell time, bolt, front: 0.000 s
Man. can change, lower speed: ON
115 Delivery normal
+/_
0..9

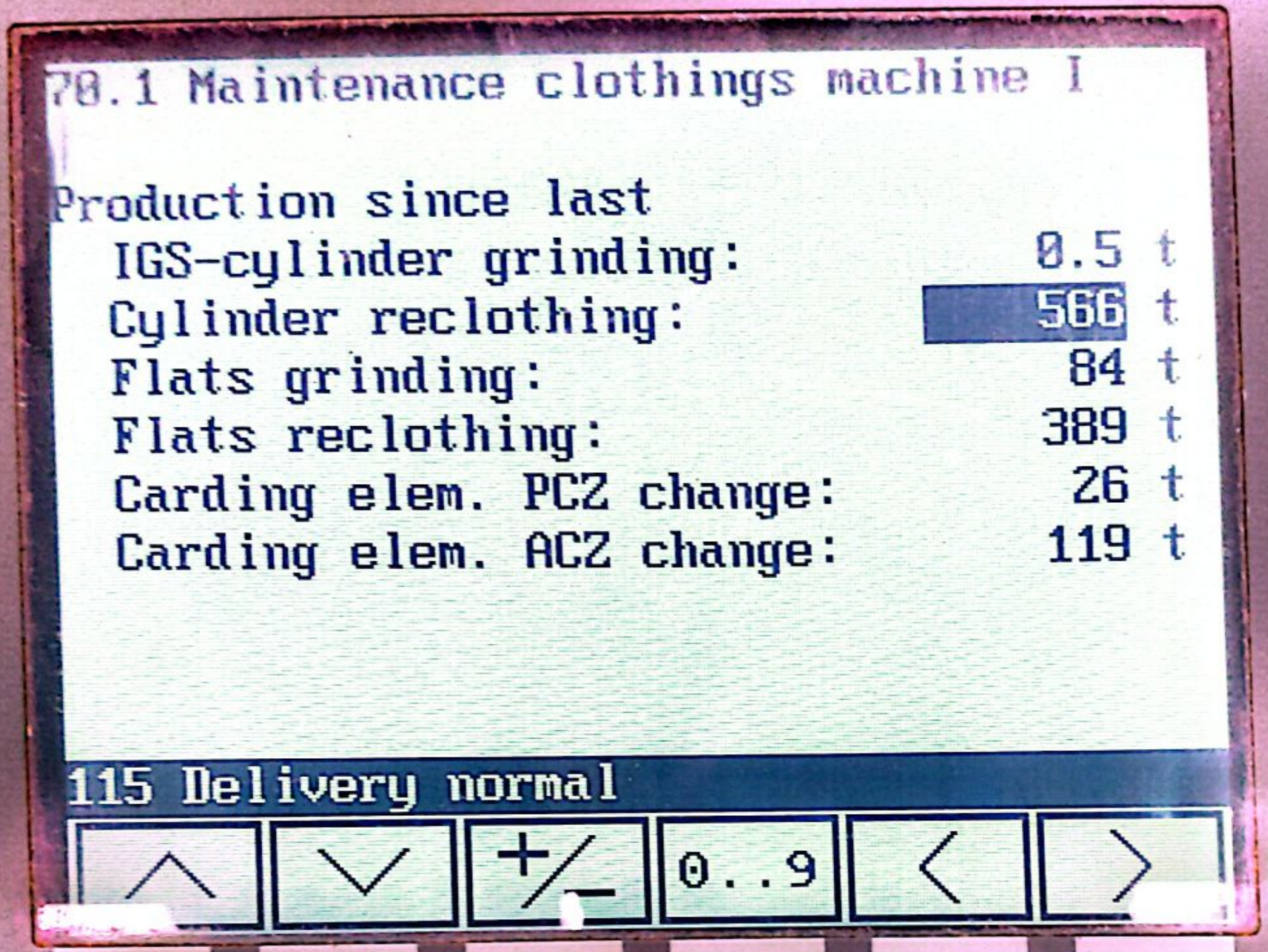

43.1 Machine configuration
Card type: C 70H
Licker-in type: 1
Cylinder drive: Converter Co/Su
Cylinder motor: 11 kW
Flat type: Revolving flats
Flats drive: Tornado
U11/U12 interc.activ.:ON
Coiler: CBA-5-1000
Disk rolls: 9 mm
115 Delivery normal

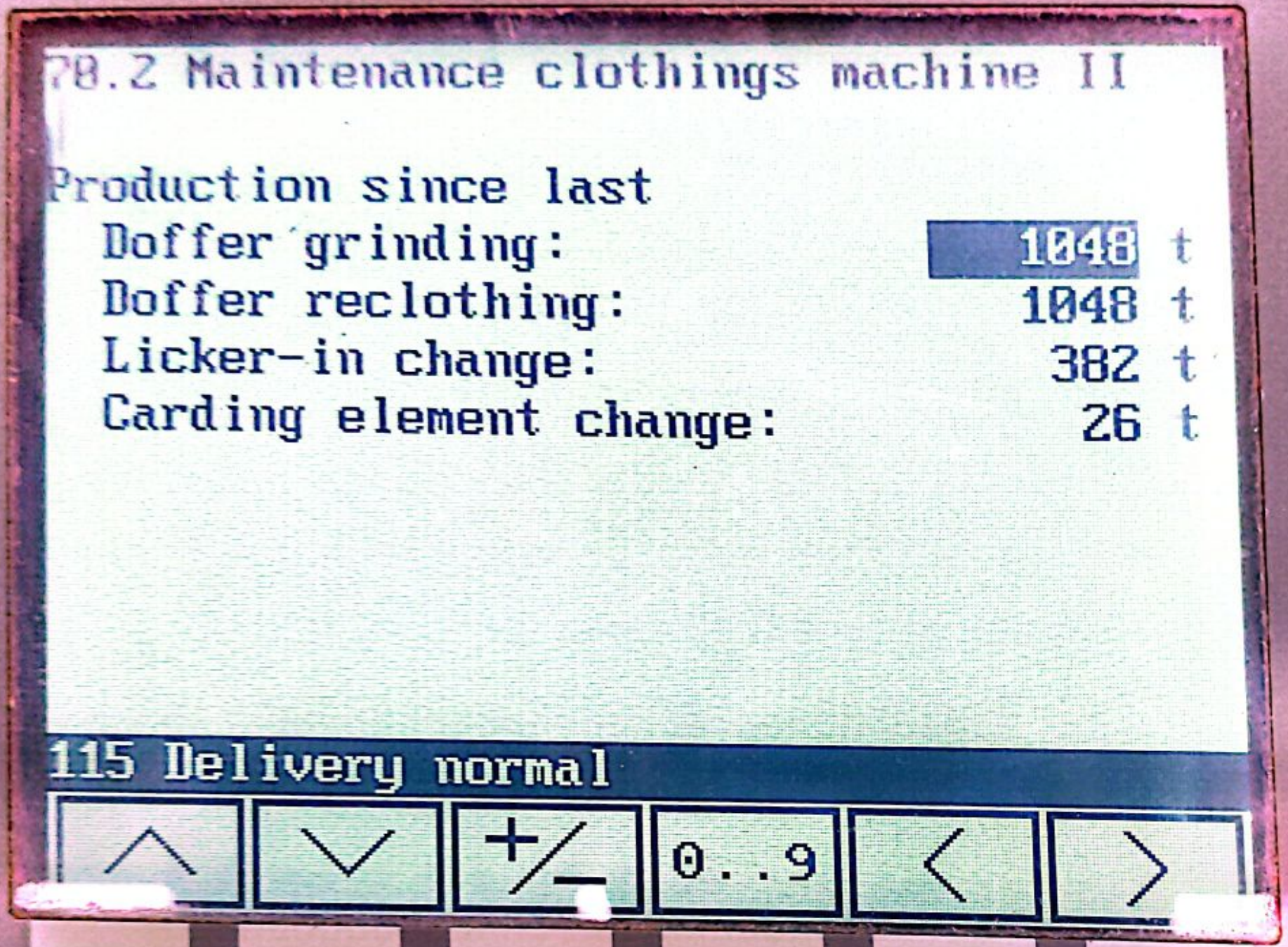

43.2 Configuration options
Network: No 172.027.010.001
IGS-classic (cylinder): Yes
IGS-top (flats): No
Uster Sliverguard: No
Chute
Autolevelling: Filling level
Drive opening roller: Change gears
Licker-in type
Vane transposition: Manual
Drive: Change gears
115 Delivery normal

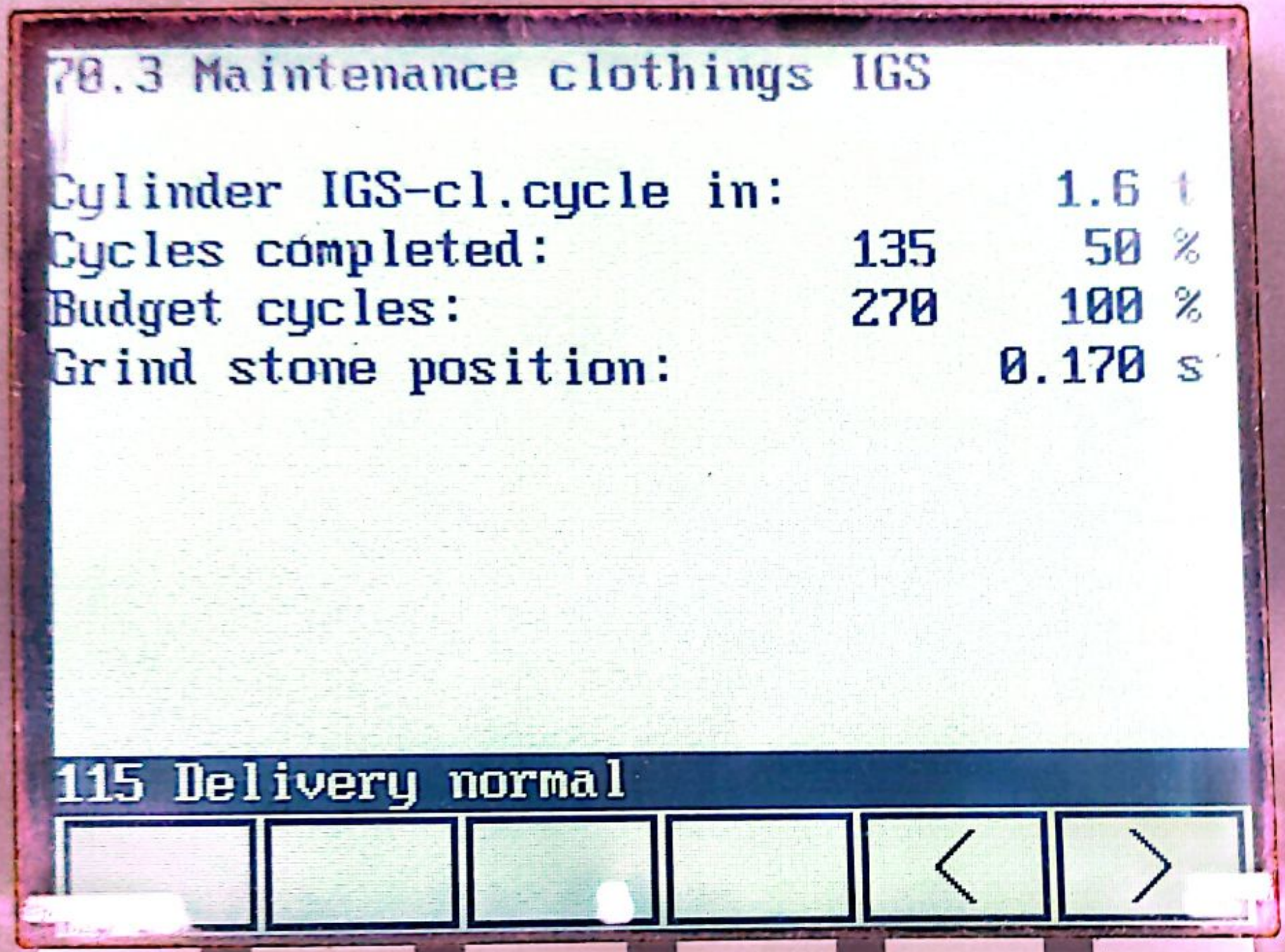

43.30 Reset configuration
Drive coiler: FC delivery U12
Flap for card suction system: No
Test KSS: No
Reset values and functions: No
115 Delivery normal

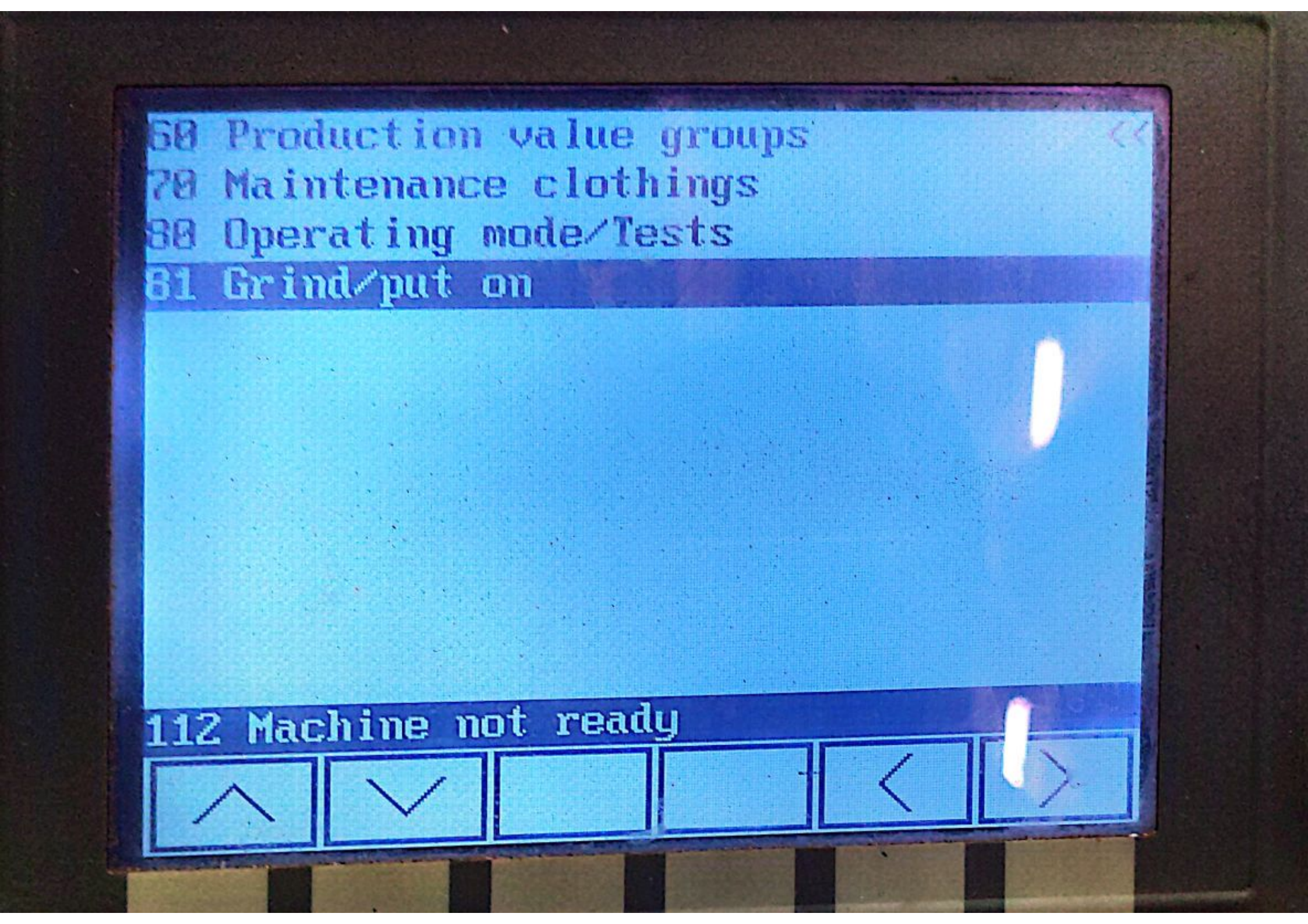

50.1 Configuration shift selection
Shift switchover:
Shift schedu
115 Delivery normal

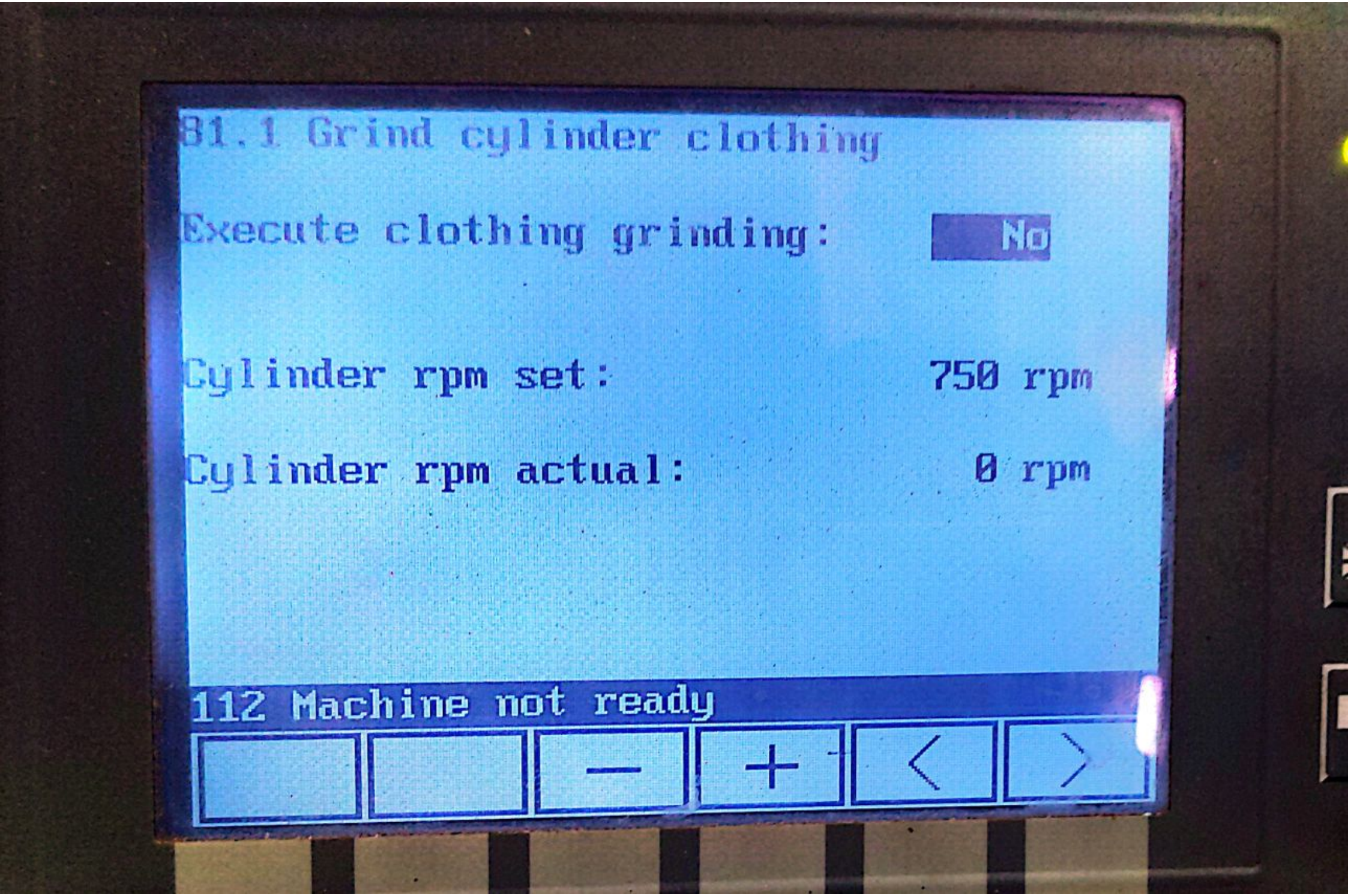

50.2 Configuration shifts shift schedule
No action
Monday
1:y 05:40
2:y 13:40
3:y 21:40
4:n 00:00
5:n 00:00
6:n 00:00
7:n 00:00
8:n 00:00
Monday
1:y 05:40
2:y 13:40
3:y 21:40
4:n 00:00
5:n 00:00
6:n 00:00
7:n 00:00
8:n 00:00
115 Delivery normal

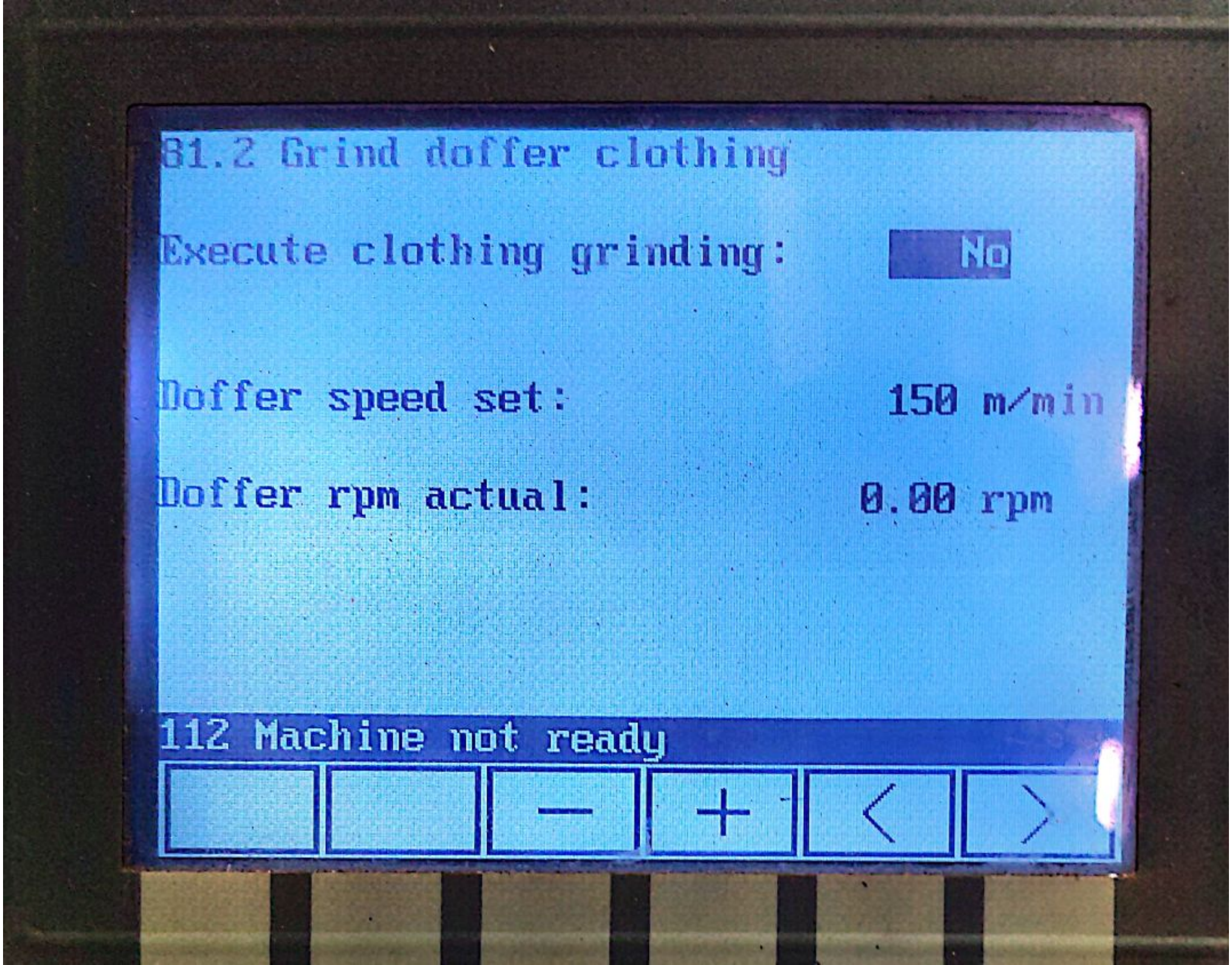

70.1 Maintenance clothings machine I
Production since last
IGS-cylinder grinding: 0.5 t
Cylinder reclothing: 566 t
Flats grinding: 84 t
Flats reclothing: 389 t
Carding elem. PCZ change: 26 t
Carding elem. ACZ change: 119 t
115 Delivery normal
+/-
0..9

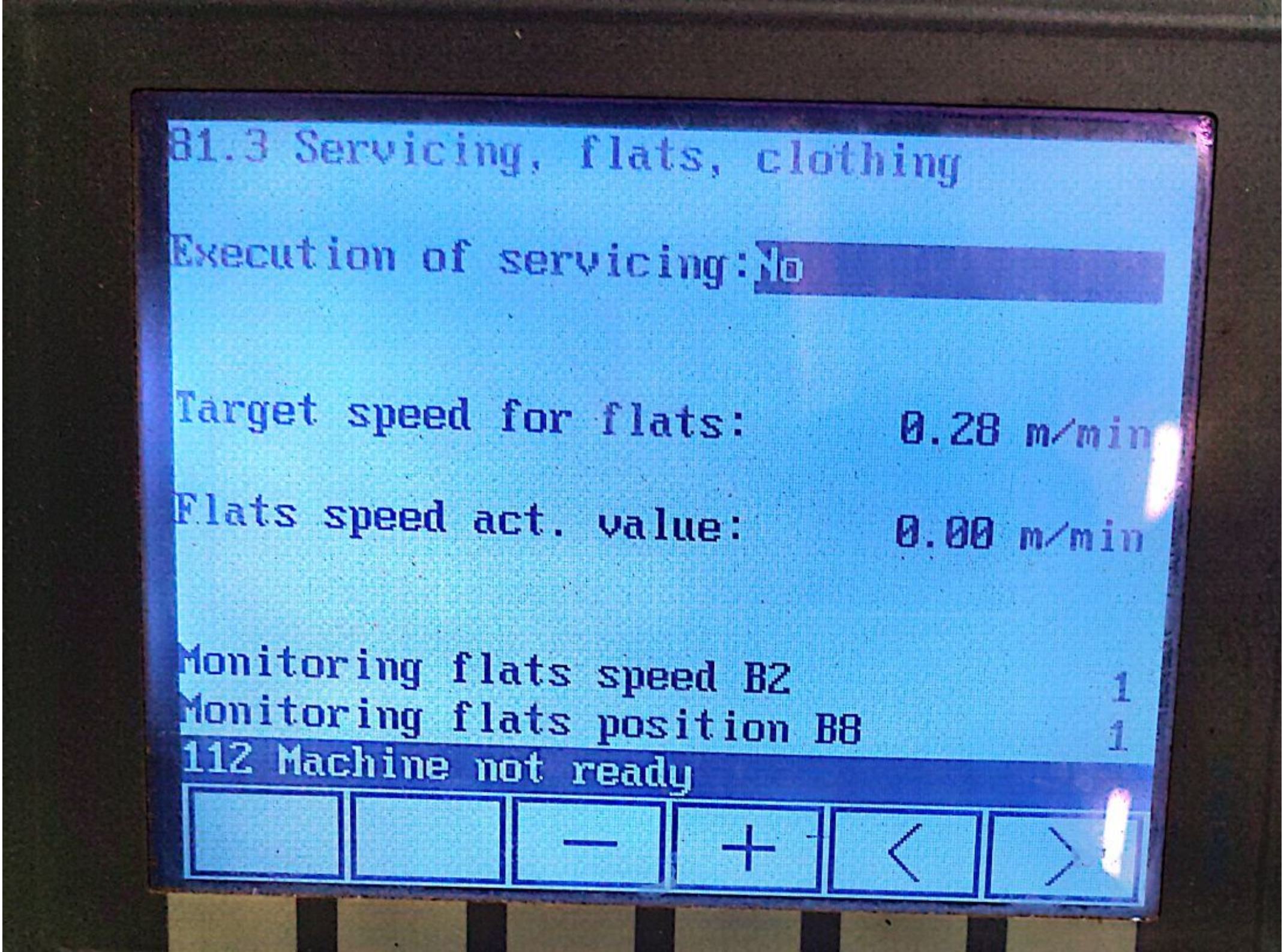

78.2 Maintenance clothings machine II
Production since last
Doffer grinding: 1048 t
Doffer reclothing: 1048 t
Licker-in change: 382 t
Carding element change: 26 t
115 Delivery normal
+/-
0..9

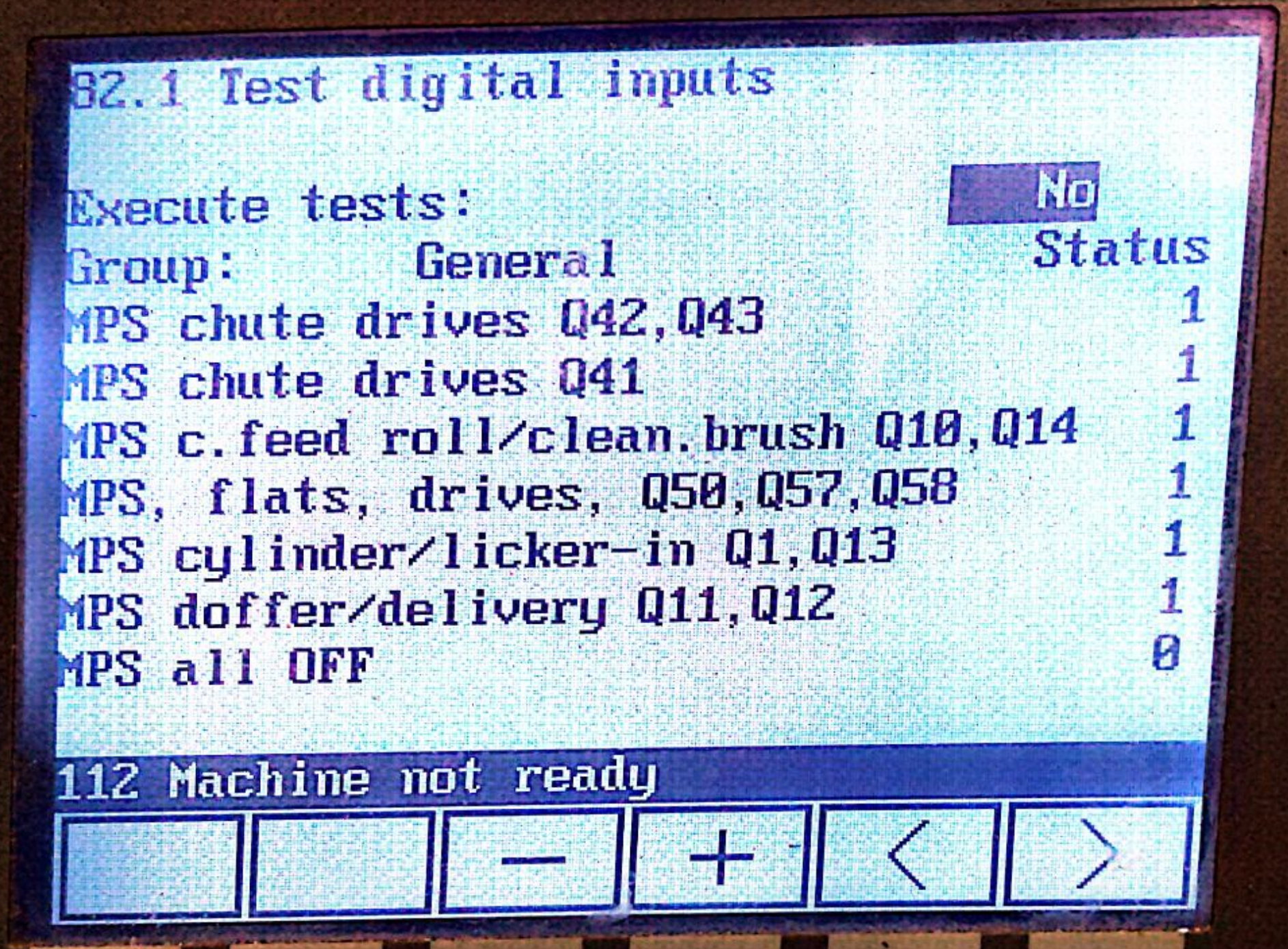

78.3 Maintenance clothings IGS
Cylinder IGS-cl.cycle in: 1.6 t
Cycles completed: 135 50 %
Budget cycles: 270 100 %
Grind stone position: 0.170 s
115 Delivery normal

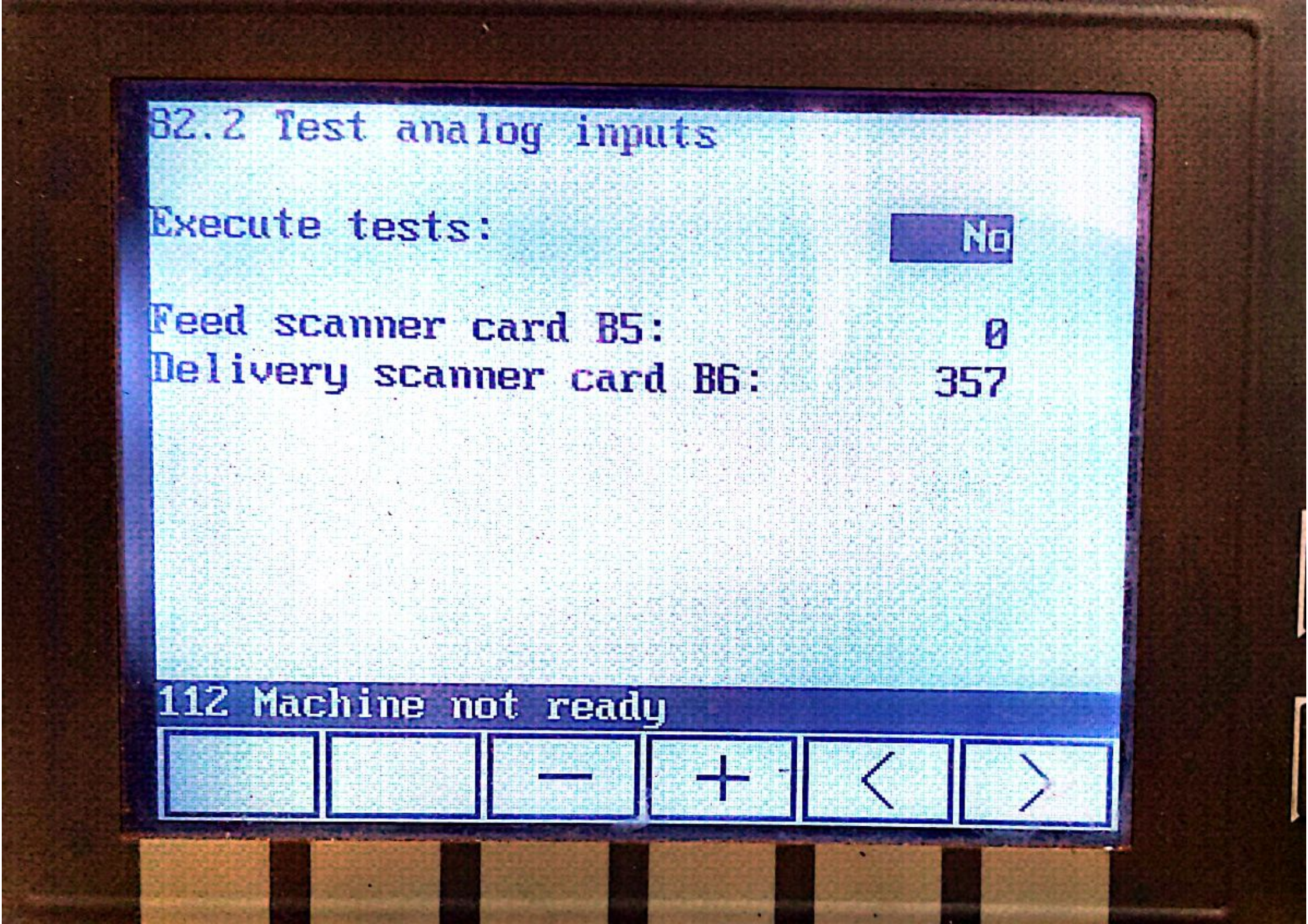

60 Production value groups
70 Maintenance clothings
80 Operating mode/Tests
81 Grind/put on
112 Machine not ready

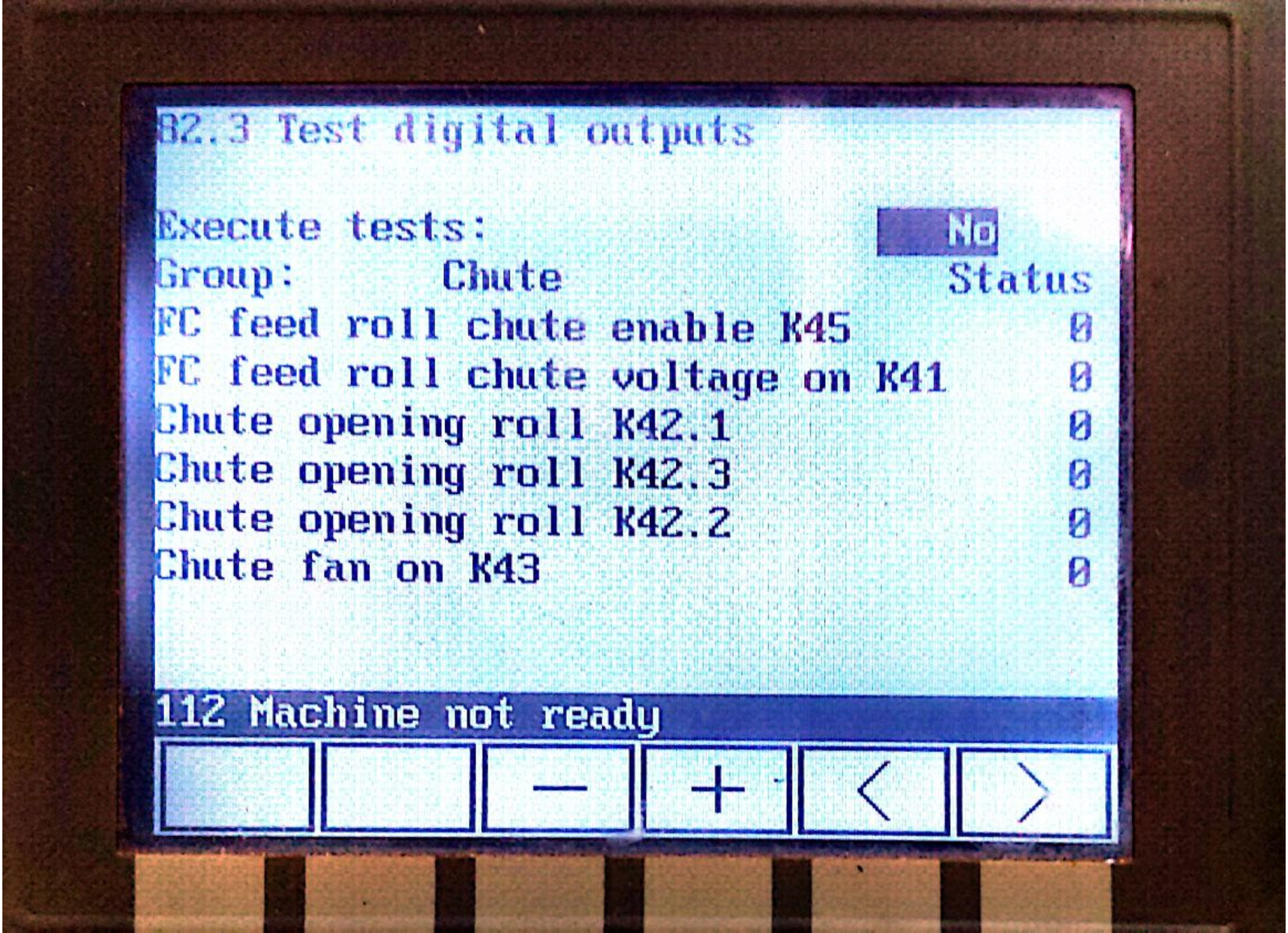

81.1 Grind cylinder clothing
Execute clothing grinding:
No
Cylinder rpm set:
750 rpm
Cylinder rpm actual:
0 rpm
112 Machine not ready
—
+

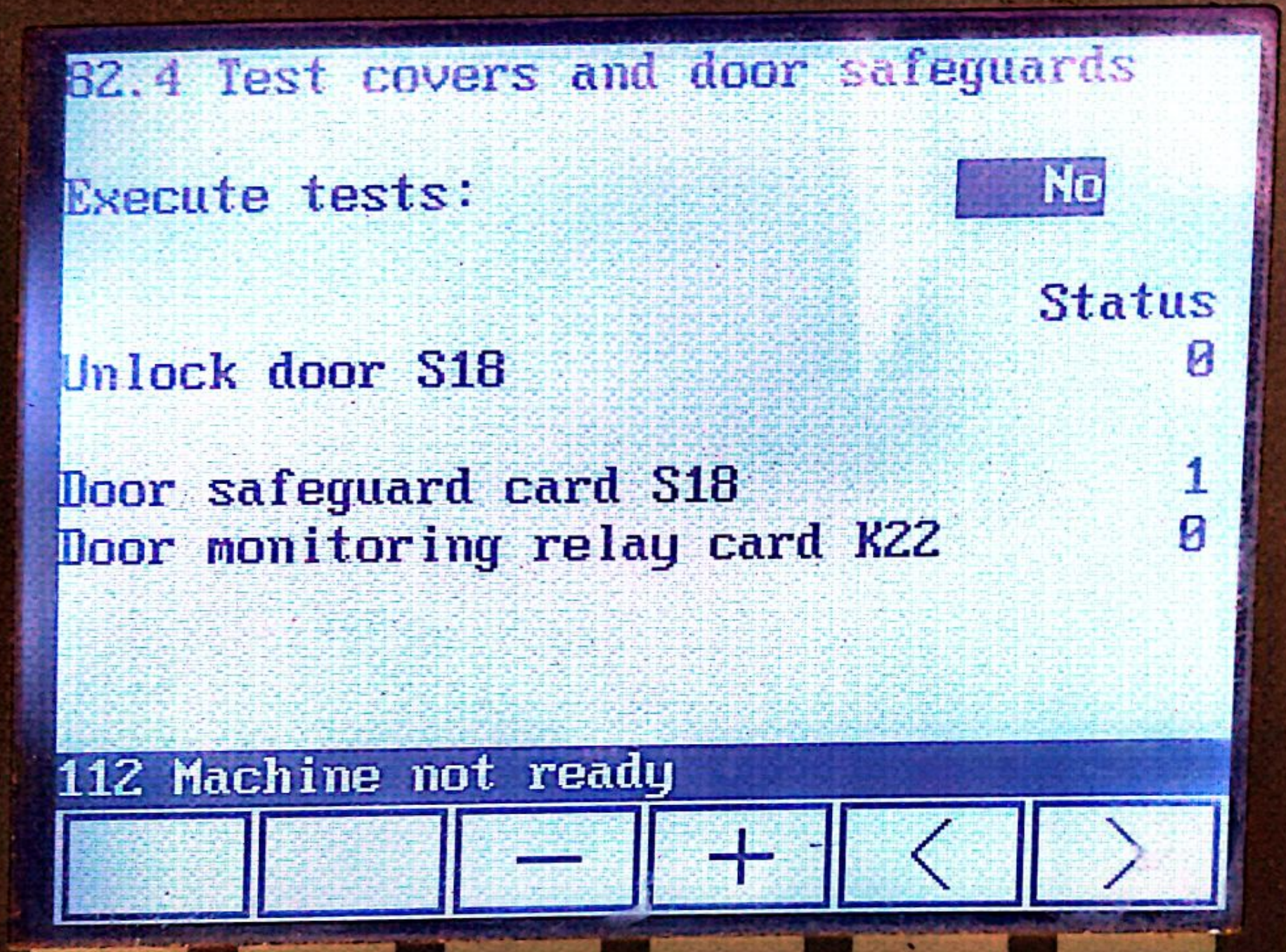

81.2 Grind doffer clothing
Execute clothing grinding:
No
Doffer speed set:
150 m/min
Doffer rpm actual:
0.00 rpm
112 Machine not ready
—
+

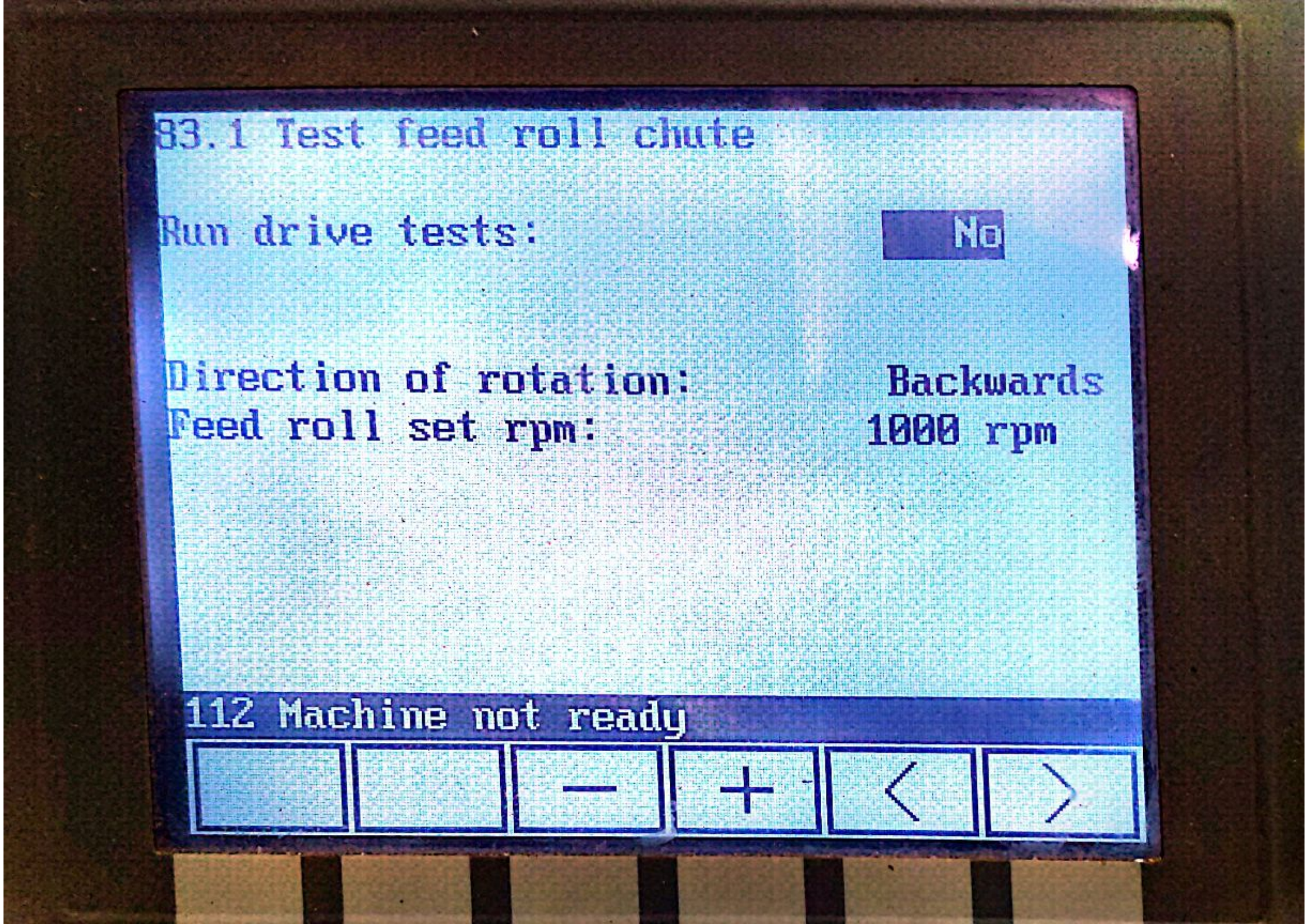

B1.3 Servicing, flats, clothing
Execution of servicing: No
Target speed for flats: 0.28 m/min
Flats speed act. value: 0.00 m/min
Monitoring flats speed B2 1
Monitoring flats position B8 1
112 Machine not ready

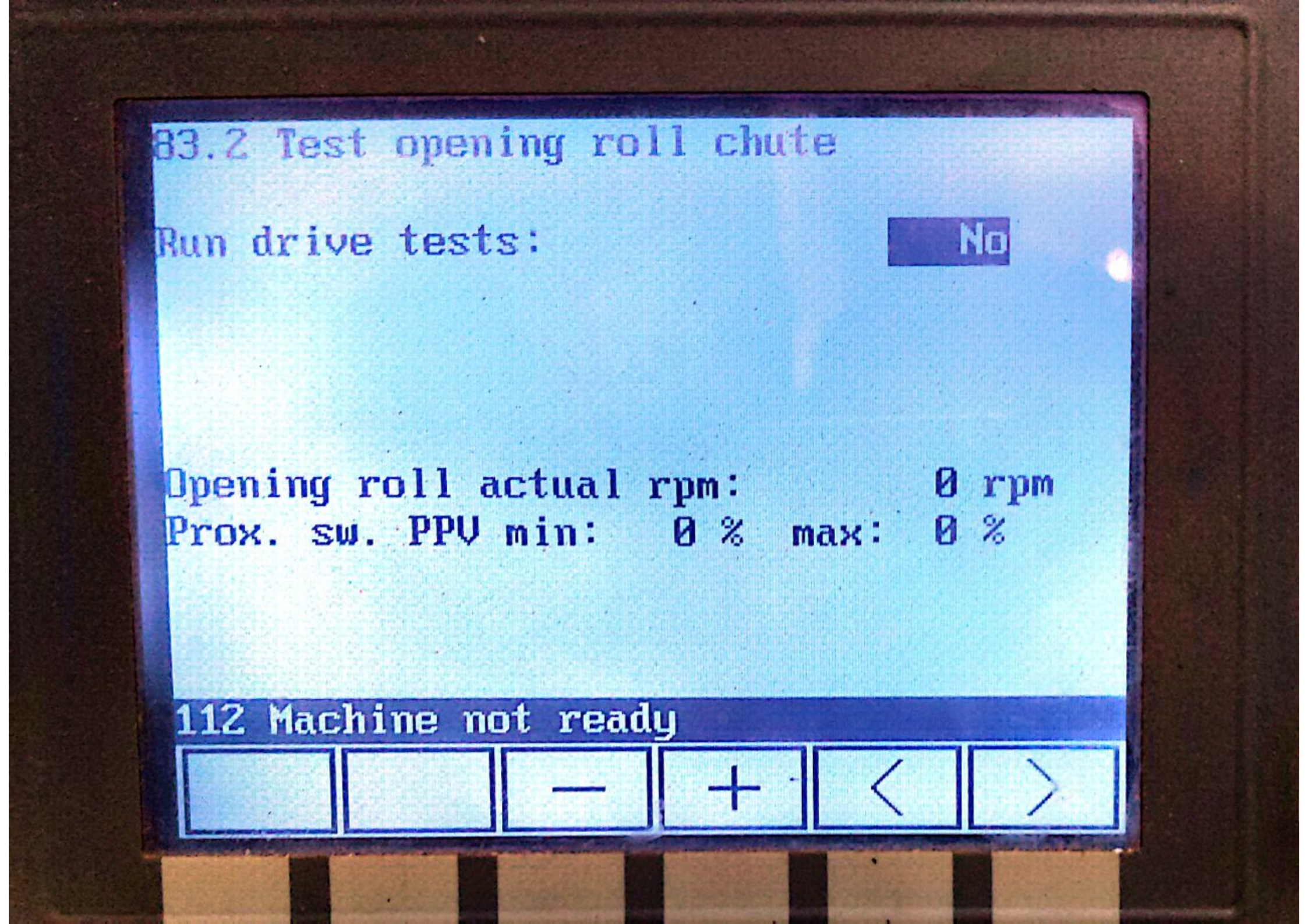

82.1 Test digital inputs
Execute tests:
No
Group: General
Status
MPS chute drives Q42,Q43 1
MPS chute drives Q41 1
MPS c.feed roll/clean.brush Q10,Q14 1
MPS, flats, drives, Q50,Q57,Q58 1
MPS cylinder/licker-in Q1,Q13 1
MPS doffer/delivery Q11,Q12 1
MPS all OFF 0
112 Machine not ready

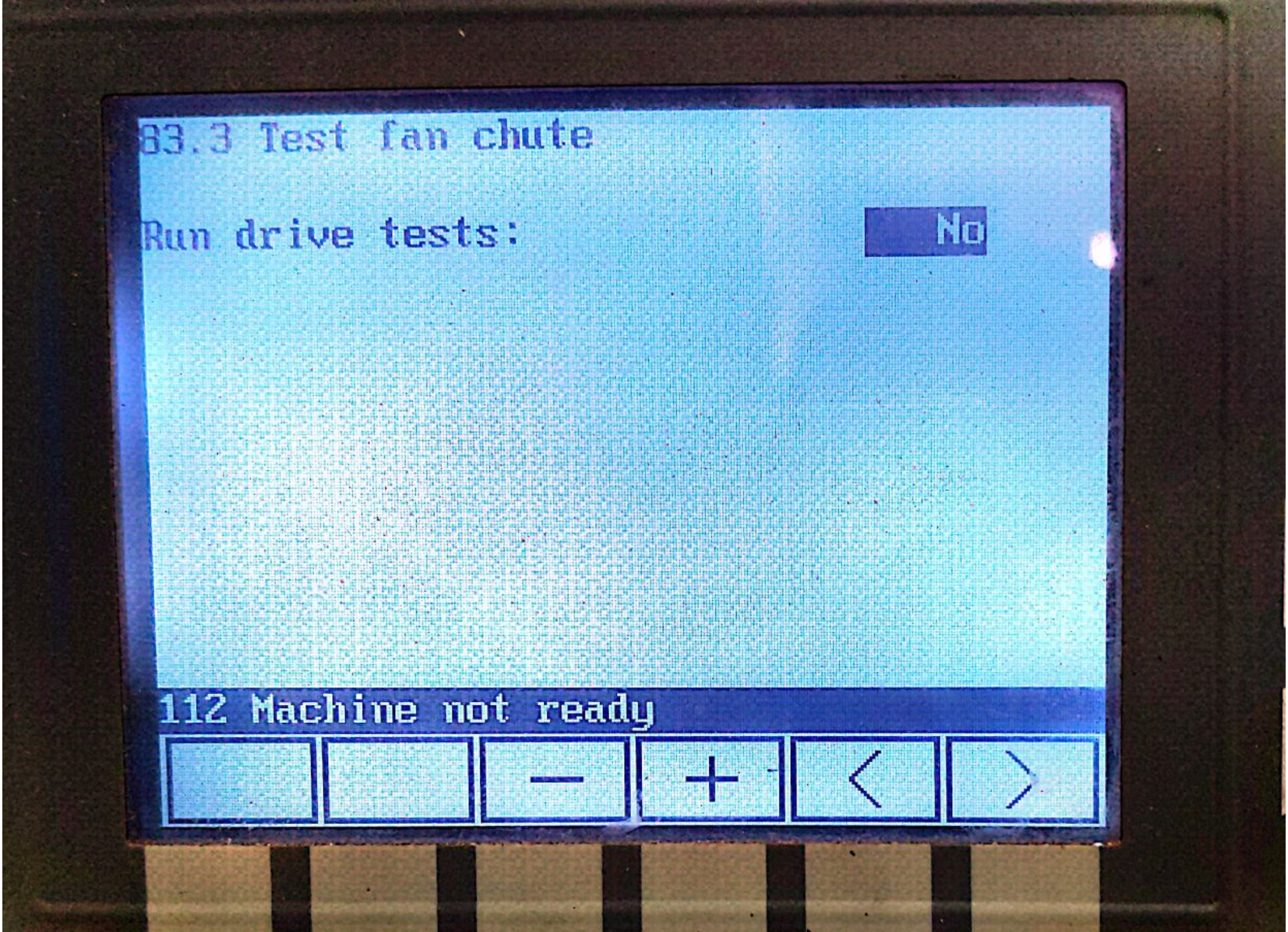

82.2 Test analog inputs
Execute tests:
No
Feed scanner card B5:
0
Delivery scanner card B6:
357
112 Machine not ready

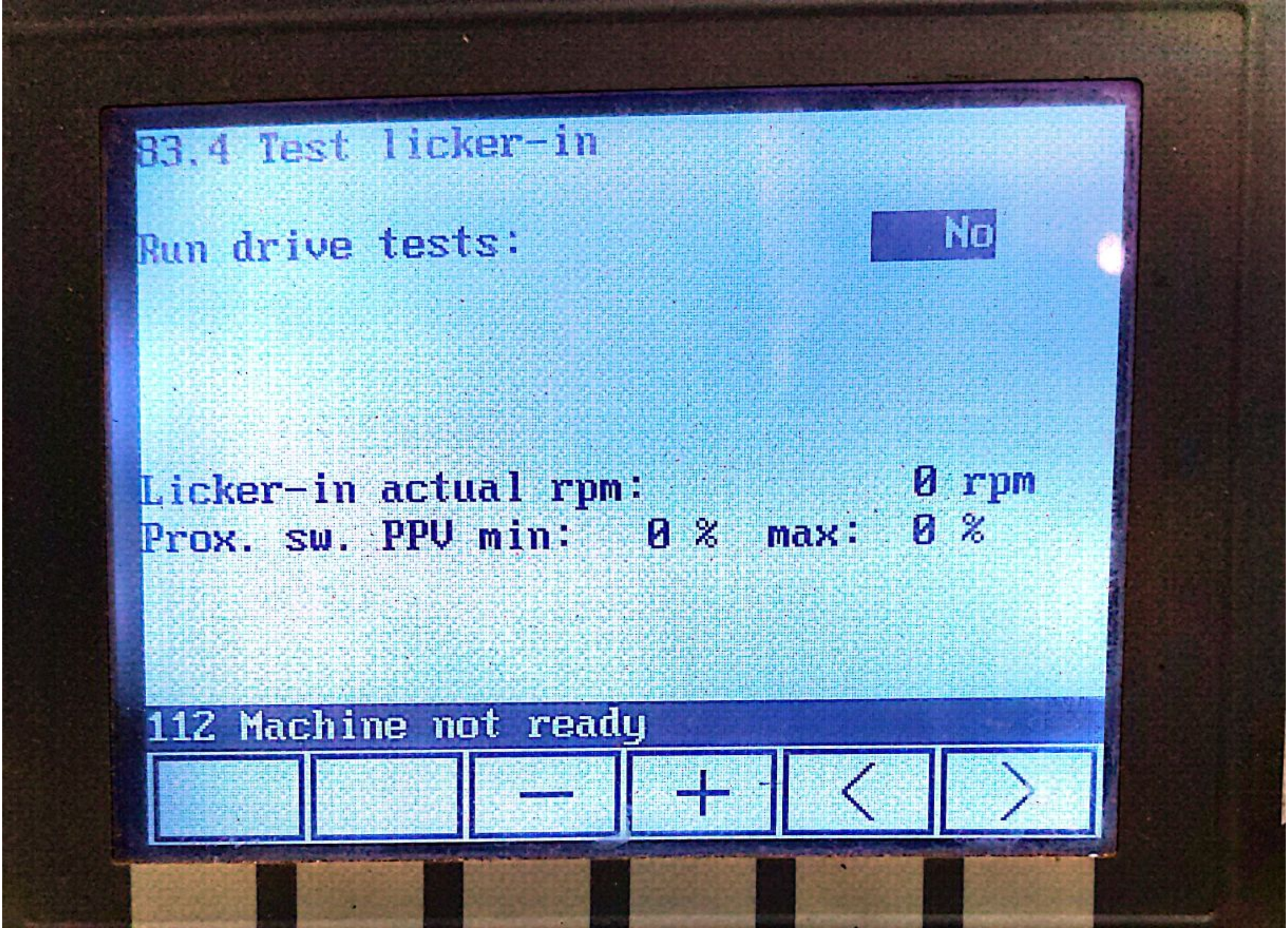

82.3 Test digital outputs
Execute tests: No
Group: Chute Status
FC feed roll chute enable K45 0
FC feed roll chute voltage on K41 0
Chute opening roll K42.1 0
Chute opening roll K42.3 0
Chute opening roll K42.2 0
Chute fan on K43 0
112 Machine not ready
—
+

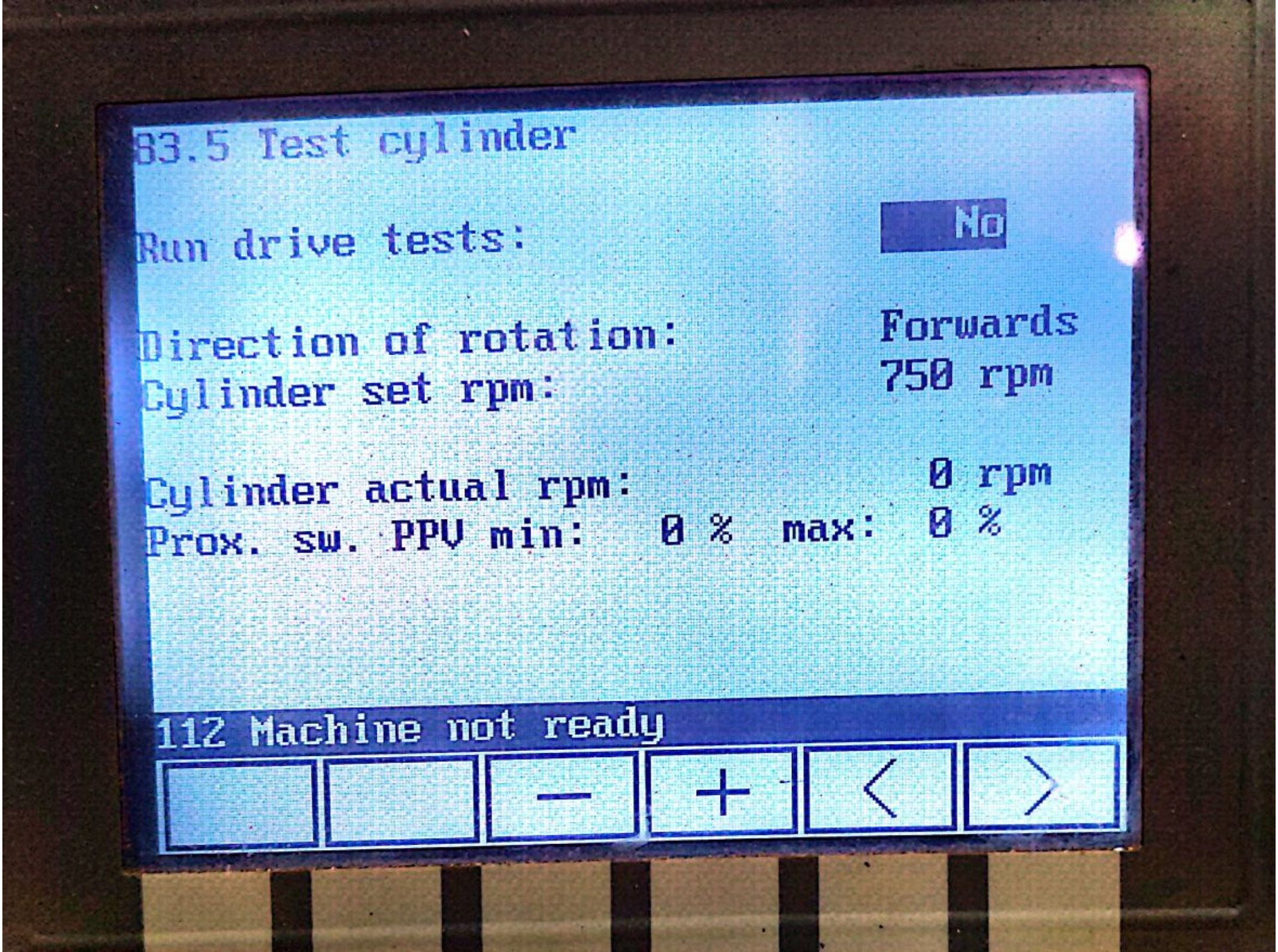

82.4 Test covers and door safeguards
Execute tests:
No
Status
Unlock door S18
0
Door safeguard card S18
1
Door monitoring relay card K22
0
112 Machine not ready

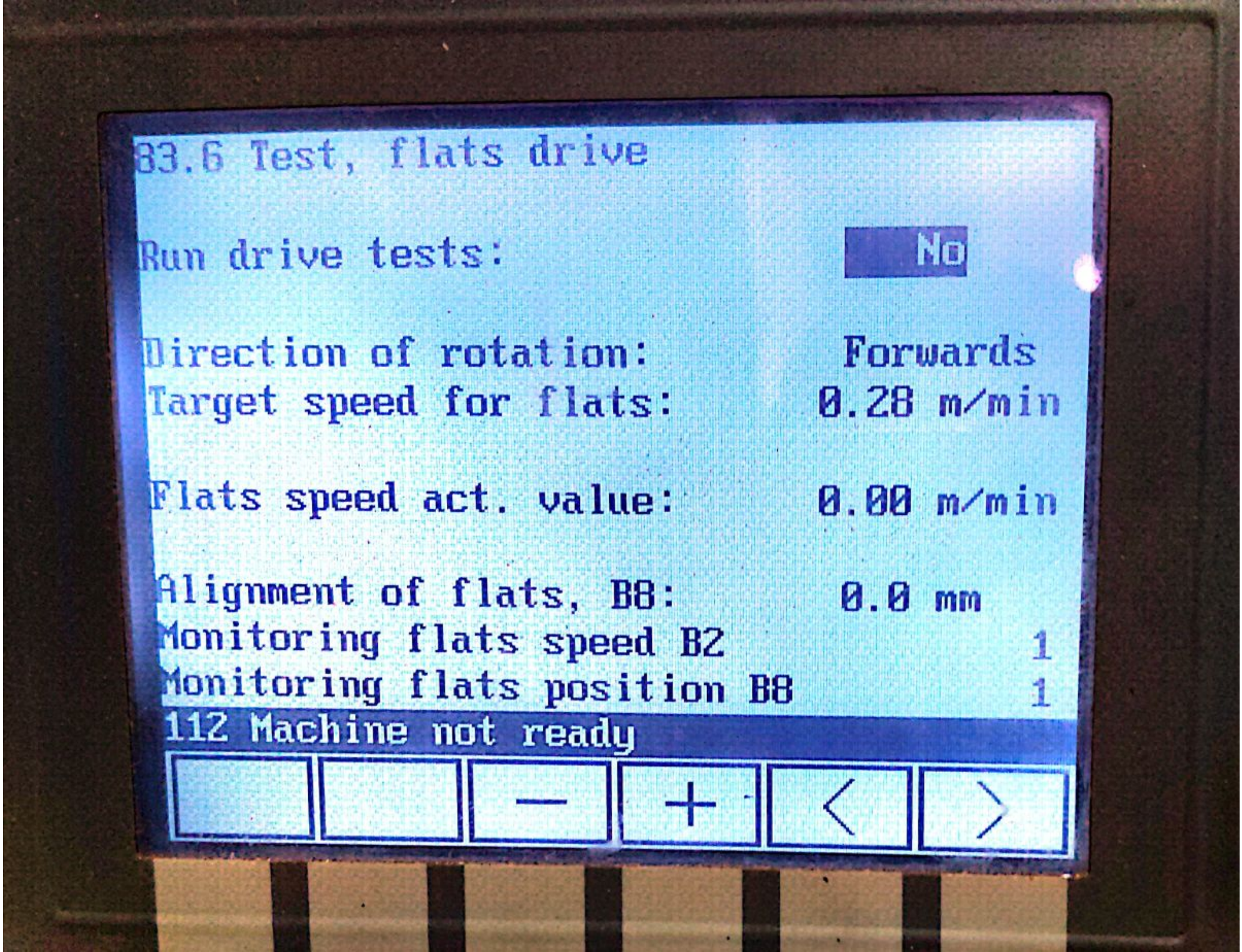

83.1 Test feed roll chute
Run drive tests:
No
Direction of rotation:
Backwards
Feed roll set rpm:
1000 rpm
112 Machine not ready
-
+

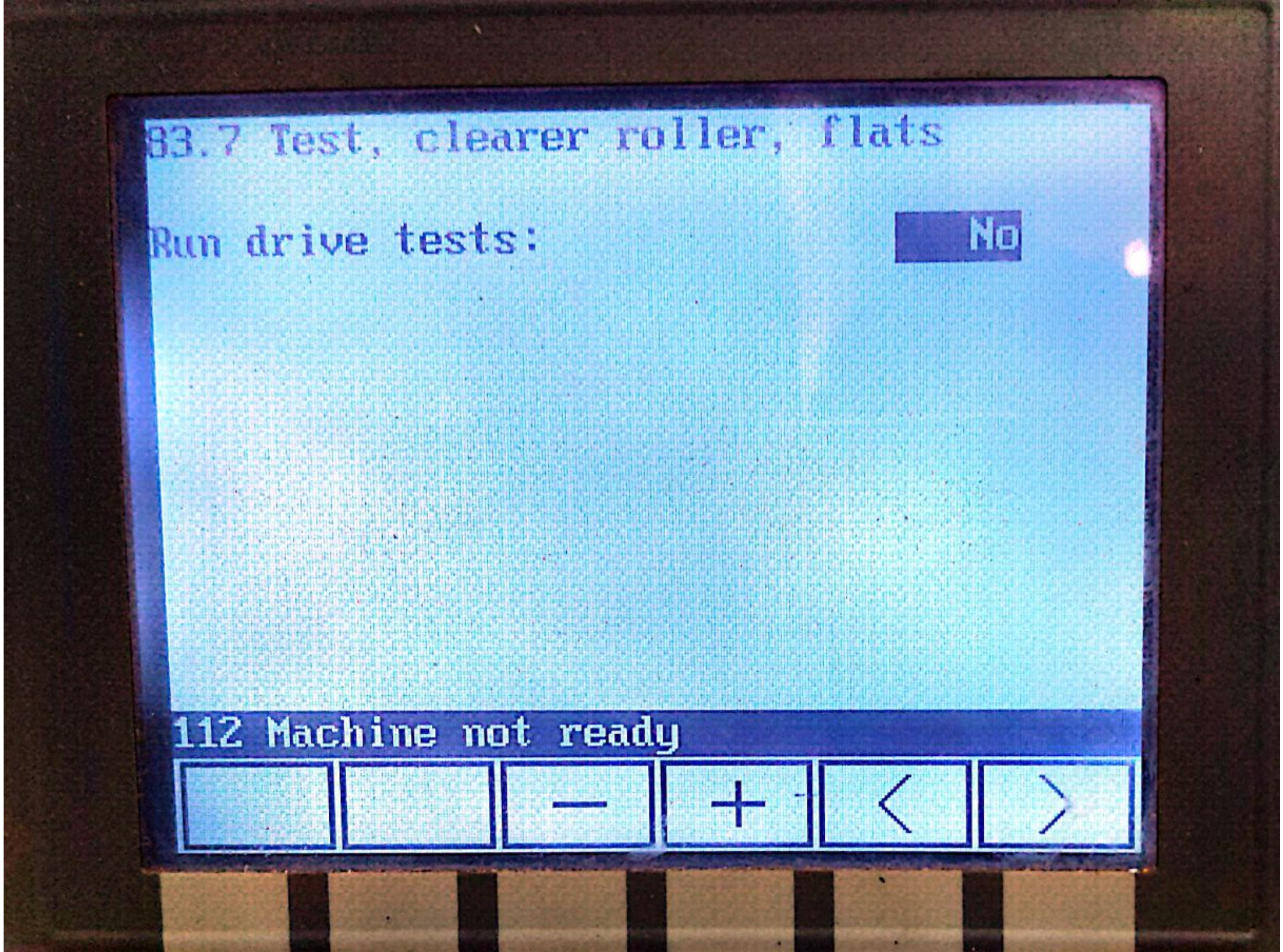

83.2 Test opening roll chute
Run drive tests:
No
Opening roll actual rpm: 0 rpm
Prox. sw. PPV min: 0 % max: 0 %
112 Machine not ready
—
+

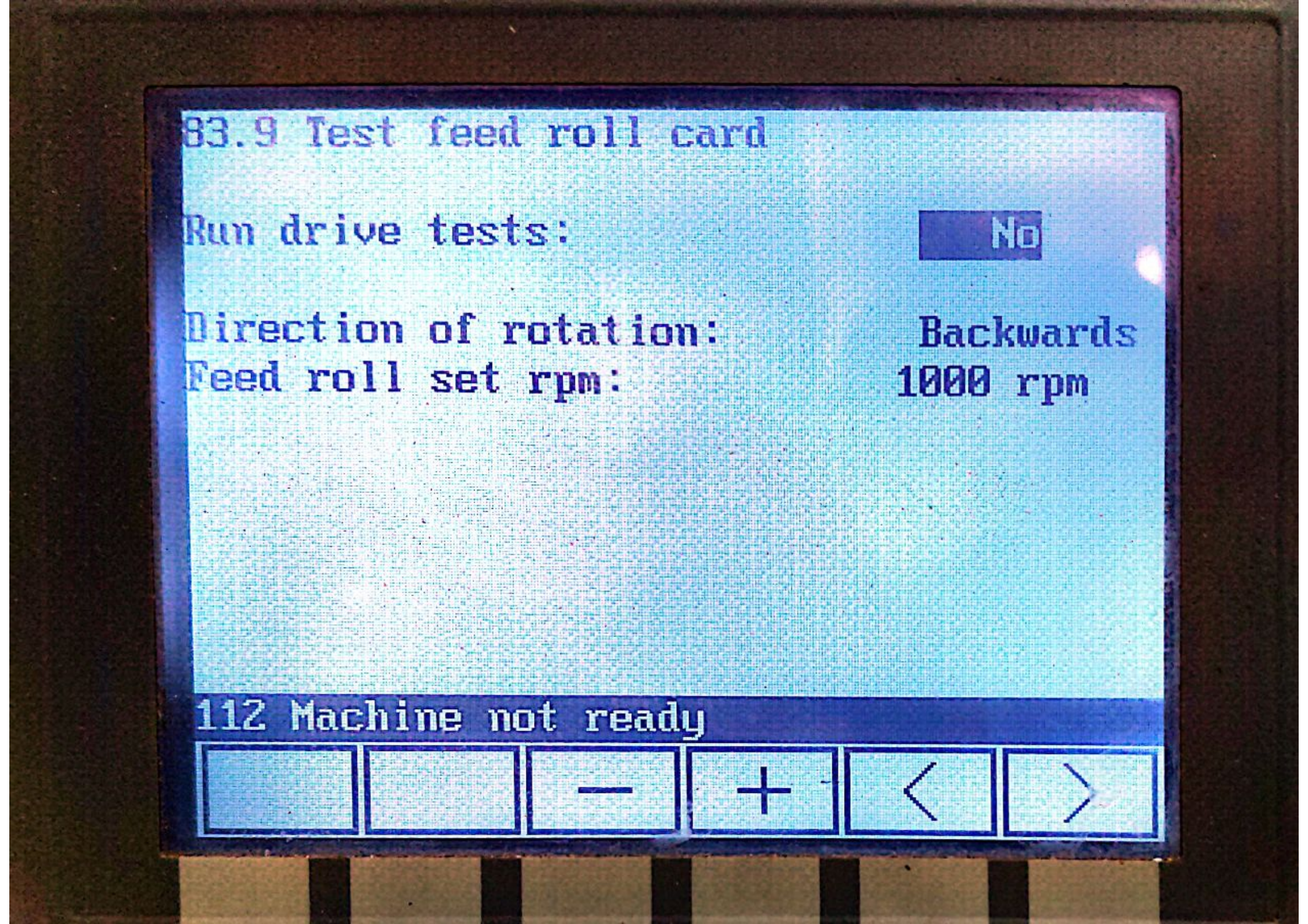

83.3 Test fan chute
Run drive tests:
No
112 Machine not ready

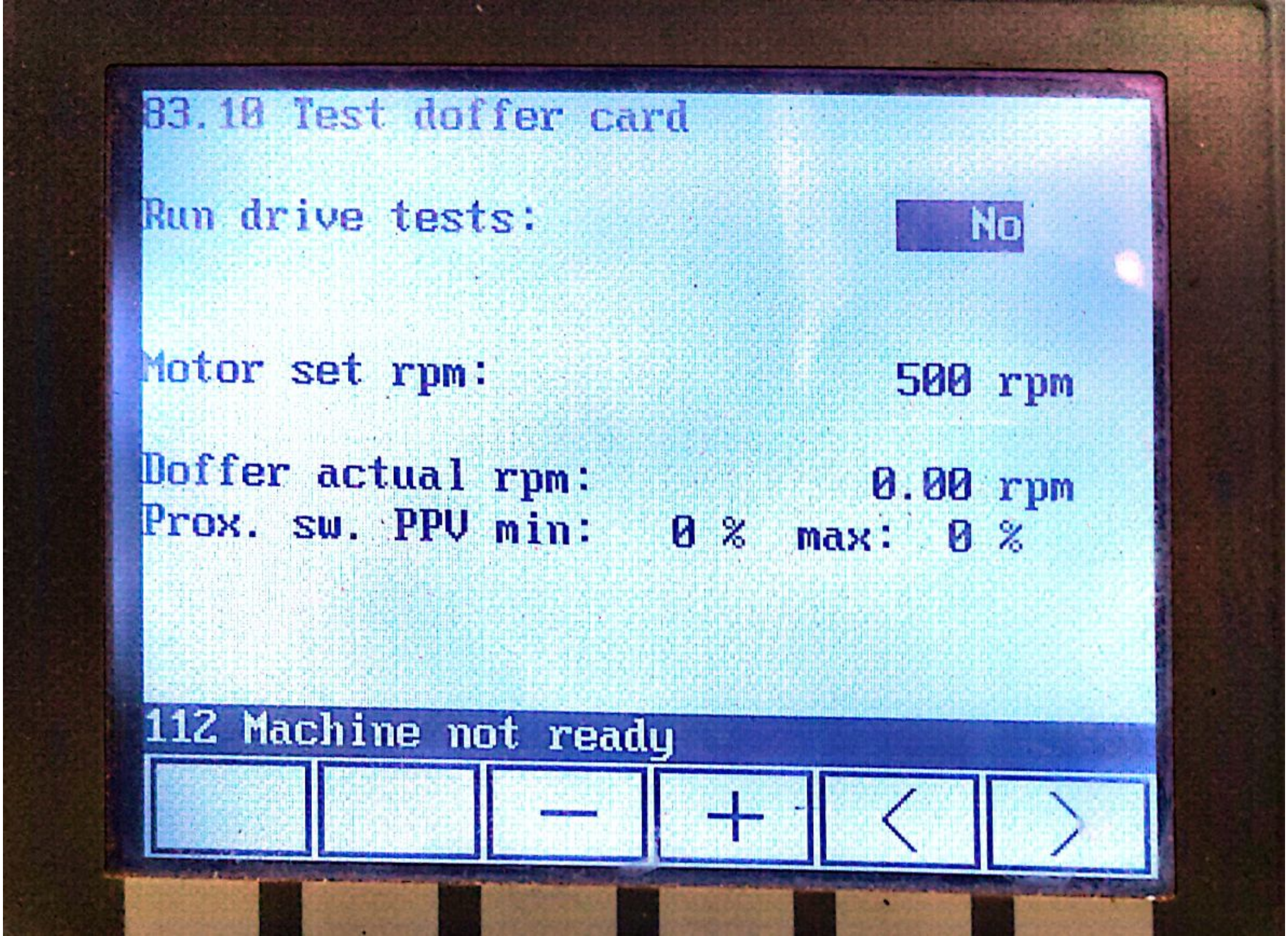

83.4 Test licker-in
Run drive tests:
No
Licker-in actual rpm:
0 rpm
Prox. sw. PPV min:
0 %
max:
0 %
112 Machine not ready
—
+

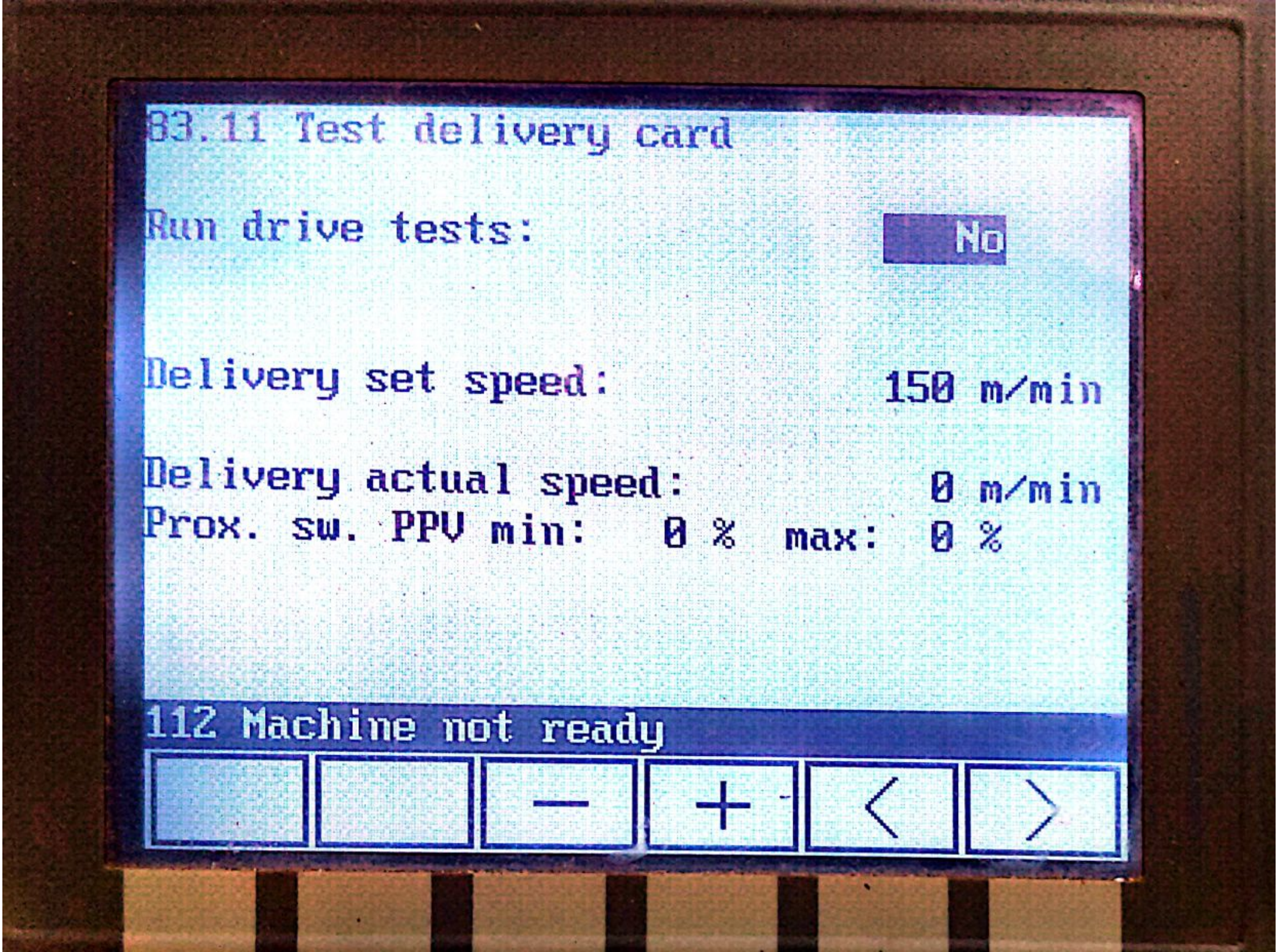

83.5 Test cylinder
Run drive tests:
No
Direction of rotation:
Forwards
Cylinder set rpm:
750 rpm
Cylinder actual rpm:
0 rpm
Prox. sw. PPV min: 0 % max: 0 %
112 Machine not ready

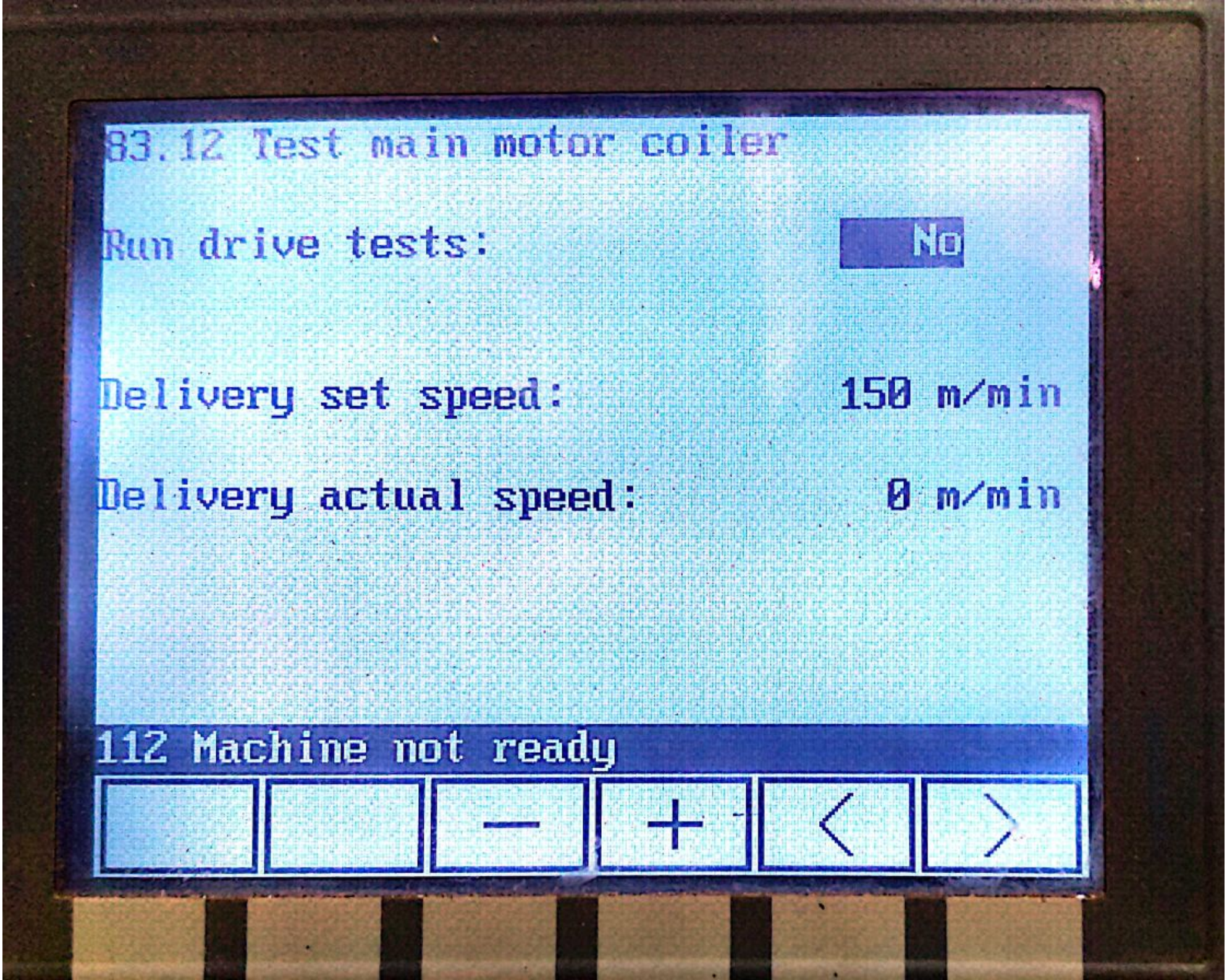

83.6 Test, flats drive
Run drive tests: No
Direction of rotation: Forwards
Target speed for flats: 0.28 m/min
Flats speed act. value: 0.00 m/min
Alignment of flats, B8: 0.0 mm
Monitoring flats speed B2 1
Monitoring flats position B8 1
112 Machine not ready

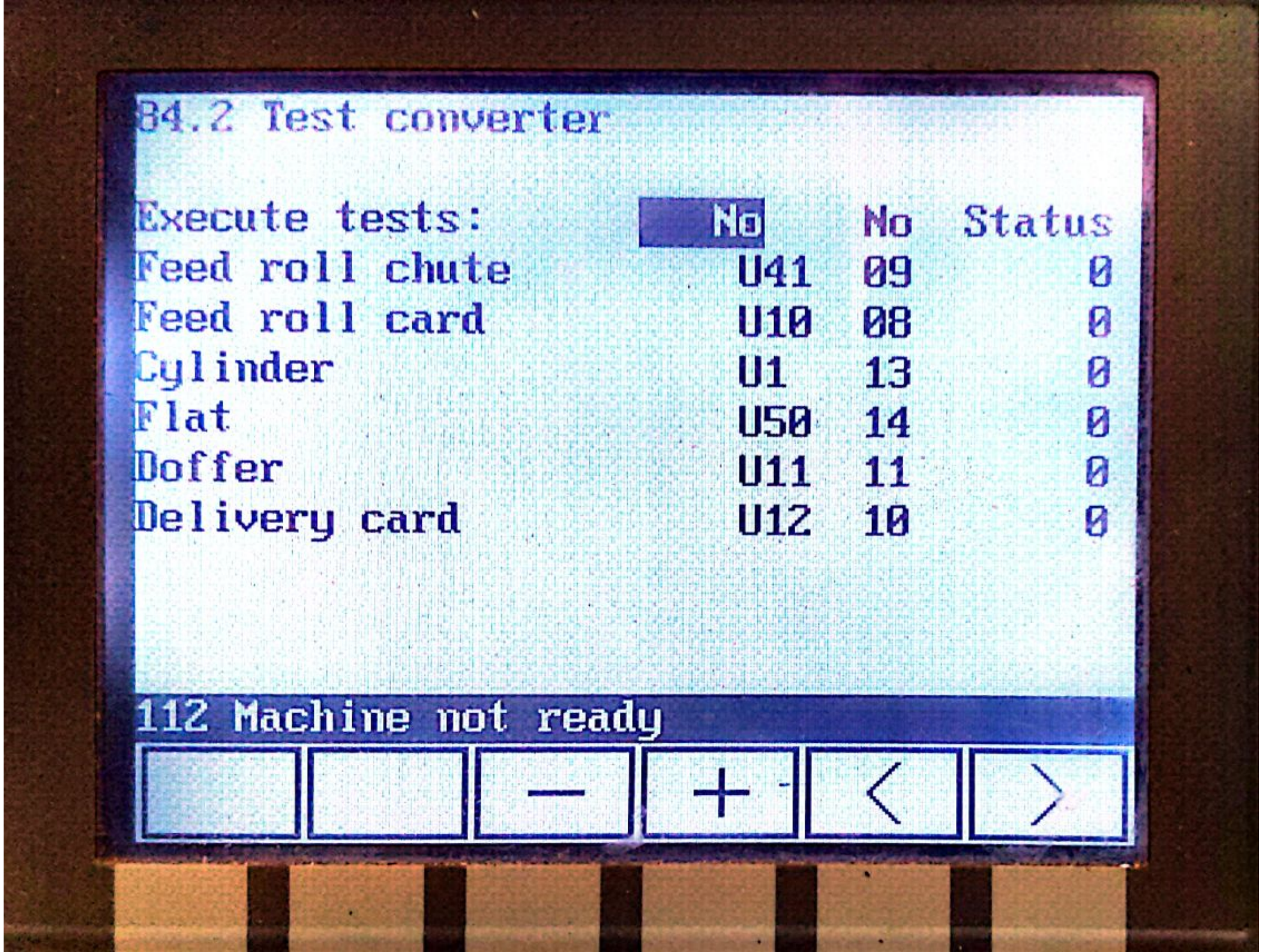

83.7 Test, clearer roller, flats
Run drive tests:
No
112 Machine not ready


83.9 Test feed roll card
Run drive tests:
No
Direction of rotation:
Backwards
Feed roll set rpm:
1000 rpm
112 Machine not ready
—
+


83.10 Test doffer card
Run drive tests:
No
Motor set rpm:
500 rpm
Doffer actual rpm:
0.00 rpm
Prox. sw. PPV min: 0 % max: 0 %
112 Machine not ready


83.11 Test delivery card
Run drive tests:
No
Delivery set speed:
150 m/min
Delivery actual speed:
0 m/min
Prox. sw. PPV min:
0 %
max:
0 %
112 Machine not ready
—
+


83.12 Test main motor coiler
Run drive tests:
No
Delivery set speed:
150 m/min
Delivery actual speed:
0 m/min
112 Machine not ready
—
+


84.2 Test converter
Execute tests:
No
No
Status
Feed roll chute
U41
09
0
Feed roll card
U10
08
0
Cylinder
U1
13
0
Flat
U50
14
0
Doffer
U11
11
0
Delivery card
U12
10
0
112 Machine not ready